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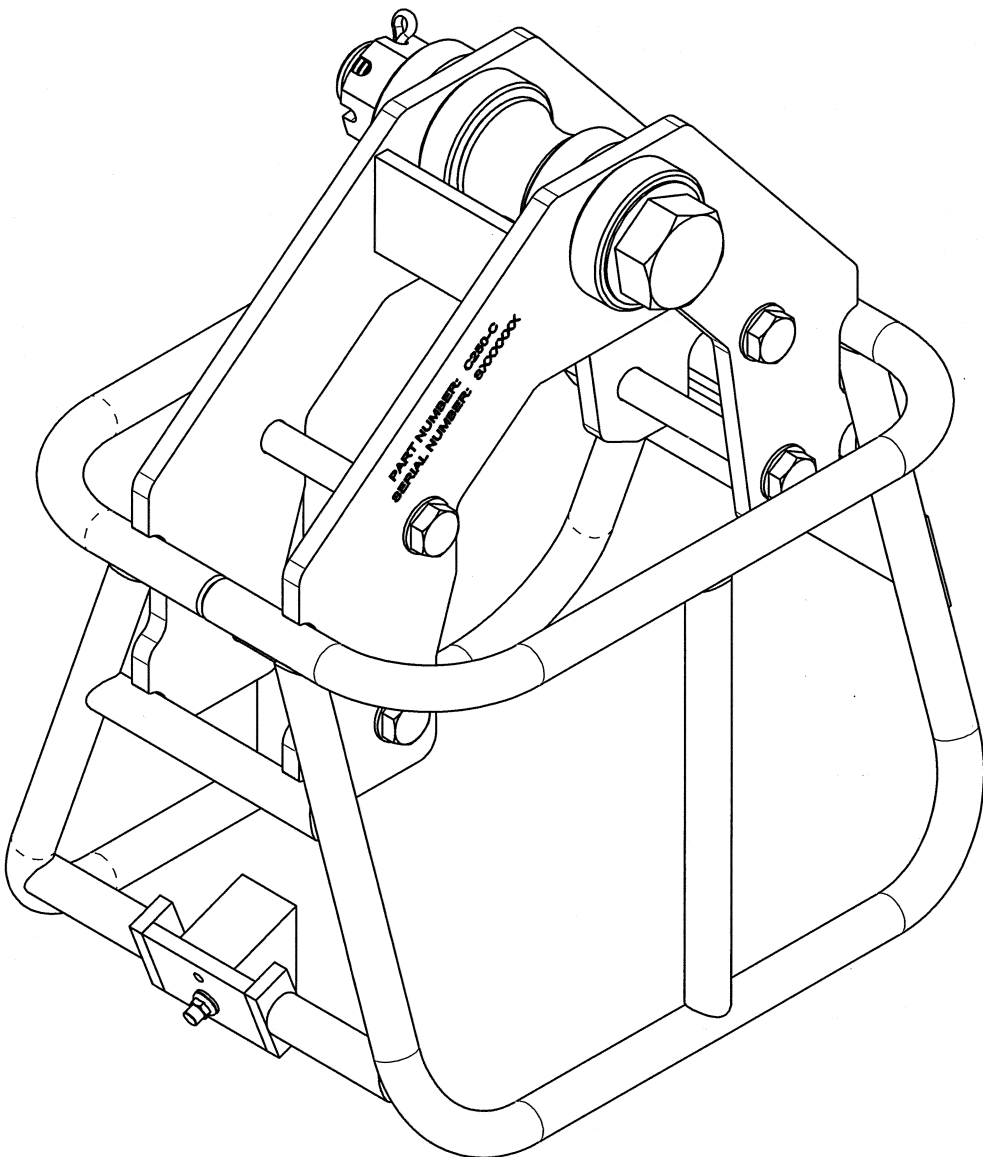
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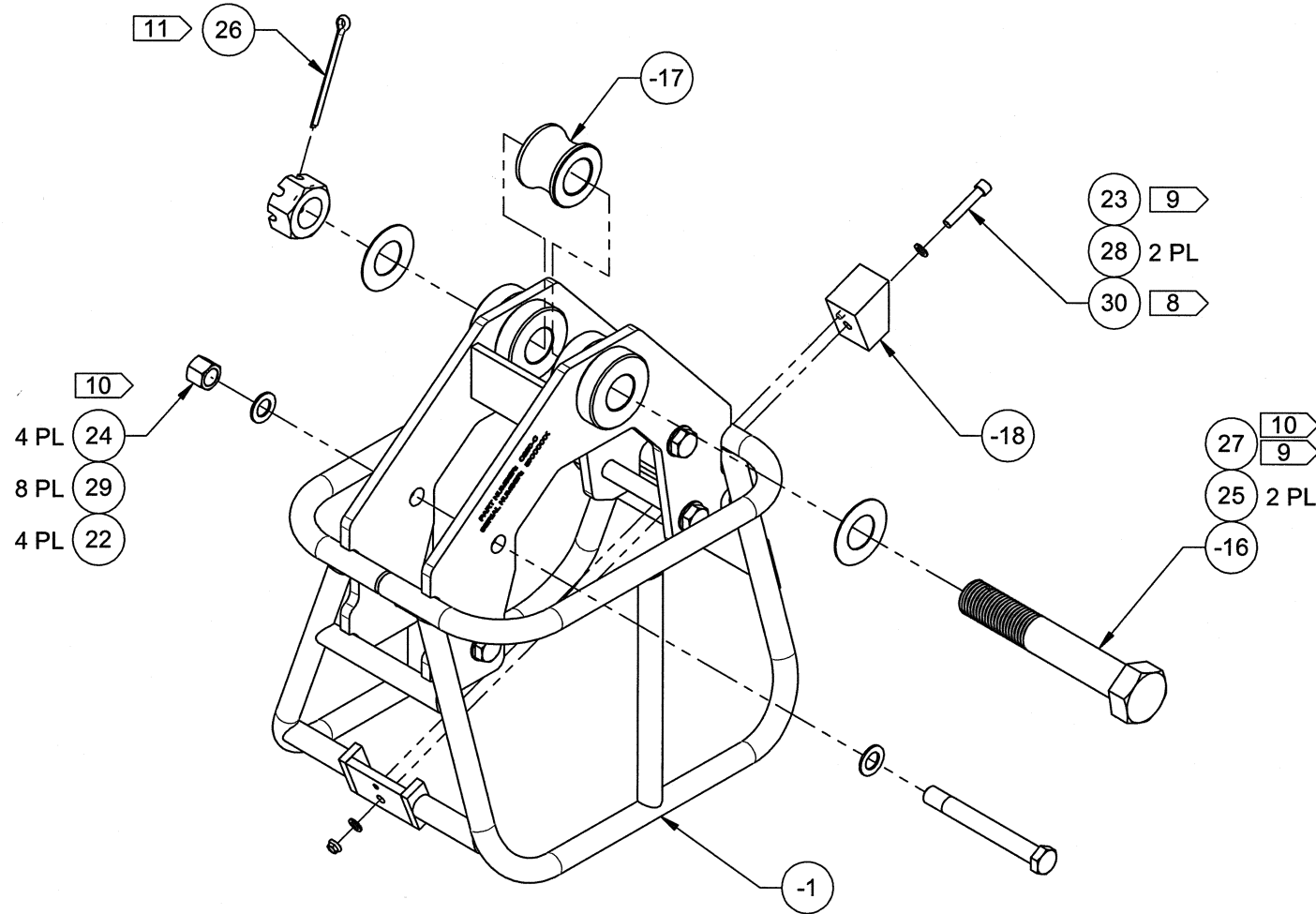


C250-C C250 CAGE ASSEMBLY

UNDER REVIEW
URF 19-891 19.09.09 (KT)



SEE PREVIOUS REVISION FOR MORE INFORMATION		19-821	KPT
UPDATED DRAWING TEMPLATE			
C250-C-1 SUPERCEDES C250-1100			
C250-C-2 SUPERCEDES C250-1100-1			
C250-C-3 SUPERCEDES C250-1100-3			
C250-C-4 SUPERCEDES C250-1100-5			
C250-C-7 SUPERCEDES C250-1100-11			
C250-C-8 SUPERCEDES C250-1100-13			
C250-C-9 SUPERCEDES C250-1100-15			
C250-C-10 SUPERCEDES C250-1100-17			
C250-C-11 SUPERCEDES C250-1100-19			
C250-C-12 SUPERCEDES C250-1100-21			
C250-C-13 SUPERCEDES C250-1100-23			
C250-C-14 SUPERCEDES C250-1100-25			
C250-C-15 SUPERCEDES C250-1100-27			
C250-C-16 SUPERCEDES PC250-1120			
C250-C-18 SUPERCEDES PC250-1100-9			
ITEM 22 AN12-61A WAS PC250-1110			
ITEM 23 MS21042-6 WAS C10-35			
ITEM 24 MS21044N12 WAS PC250-1150			
ITEM 25 MS21299-24 WAS PC250-1130			
ITEM 26 MS24665-690 WAS PC250-1170			
ITEM 27 MS35692-106 WAS PC250-1160			
ITEM 28 NAS1149F0663P WAS C10-36			
ITEM 29 NAS1149F1290P WAS PC250-1140			
C	REMOVED C250-1100-7		
ADDED C250-C-5, C250-C-6, C250-C-17, C250-C-22, ITEM 30 NAS1351-6-32P, AND ITEM 31 MS16555-646			
-1 REVISED WELDING SYMBOLS			
-3 DIM WAS Ø.438 IS Ø0.397. DIM WAS Ø.250 IS Ø0.257			
-7 ADDED STEP TO FIT INTO ITEM -9 LIFTING PLATE. DIM WAS Ø1.520 IS Ø1.531. DIM WAS 2X .04 X 45° IS 0.04 X 45.0° CMF 3 PL. REMOVED .955 DIM			
-8 DIM WAS (2X 71°) IS 71.0° 2 PL. REMOVED 7.90 DIM			
-9 DIM WAS Ø1.520 IS Ø2.000. DIM WAS Ø.780 IS Ø0.781. DIM WAS R.06 IS R0.06 4 PL. ADDED 50.7°, 38.4°, 81.8°, 18.0°, 26.1°, 3.19, 3.32, 2.06, AND 3.92 DIMS			
-11, -12, -13, -14, -15 ADDED LOCATIONS FOR Ø1.000 THRU HOLES			
-16 LIFTING BOLT WAS MANUFACTURED USING MCMASTER-CARR#91268A967 IS MANUFACTURED AS PER ASTM A354 (GRADE BD). DIMENSIONS AS PER ASME B18.2.1. DIM WAS 9.25 IS 9.00. DIM WAS 7.25±.030 IS 5.54-4.67. DIM WAS Ø.297 IS Ø0.312. ADDED 0.867 DIM. REMOVED 8.65 DIM			
-19 BUMPER WAS MANUFACTURED USING E3TZ-4730-A IS MANUFACTURED USING UHMW			
REV.	DESCRIPTION	ECN #	BY
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. C
MFG. APPR.	DD	C250-C	SHEET 1 OF 22
APPROVED		TITLE	SCALE
		C250 CAGE ASSEMBLY	NTS
DATE	2019-07-19	COPYRIGHT © 2019 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ITEM #	QTY	PART #	PART TITLE
-1	1	C250-C-1	C250 CAGE WELDMENT
-16	1	C250-C-16	LIFTING BOLT
-17	1	C250-C-17	LIFTING BUSHING
-18	1	C250-C-18	BUMPER ASSEMBLY
22	4	AN12-61A	CAD. PLATED STEEL HEX BOLT 3/4"-16 X 5-3/16" GRIP LG. X 6-13/32" LG.
23	1	MS21042-6	CAD. PLATED STEEL SELF-LOCKING HEX NUT 3/8"-24 X 0.275 HT.
24	4	MS21044N12	CAD PLATED STEEL SELF-LOCKING HEX NUT 3/4"-16 X 0.873" HT.
25	2	MS21299-24	CAD. PLATED STEEL WASHER 1.504" ID. X 2.879" OD. X 0.062" THK.
26	1	MS24665-690	CAD. PLATED STEEL COTTER PIN 5/16" DIA. X 4" LG.
27	1	MS35692-106	GRADE C CAD. PLATED STEEL CASTELLATED HEX NUT 1½"-6 X 1.281 HT.
28	2	NAS1149F0663P	CAD PLATED STEEL WASHER 0.390" ID. X 0.625" OD. X 0.063" THK.
29	8	NAS1149F1290P	CAD PLATED STEEL WASHER 0.765" ID. X 1.312" OD. X 0.090" THK.
30	1	NAS1351-6-32P	STEEL SOCKET HEAD CAP SCREW 3/8"-24 X 2" LG.



- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 30 THEN ASSEMBLE WITH ITEM 23, AND REMOVE EXCESS
 - 9) TORQUE ITEM 23 TO 13-16 FT-LBS (160-190 IN-LBS)
 - 10) INSTALL ITEMS 24 AND 27 HAND TIGHT
 - 11) DO NOT FOLD ITEM 26

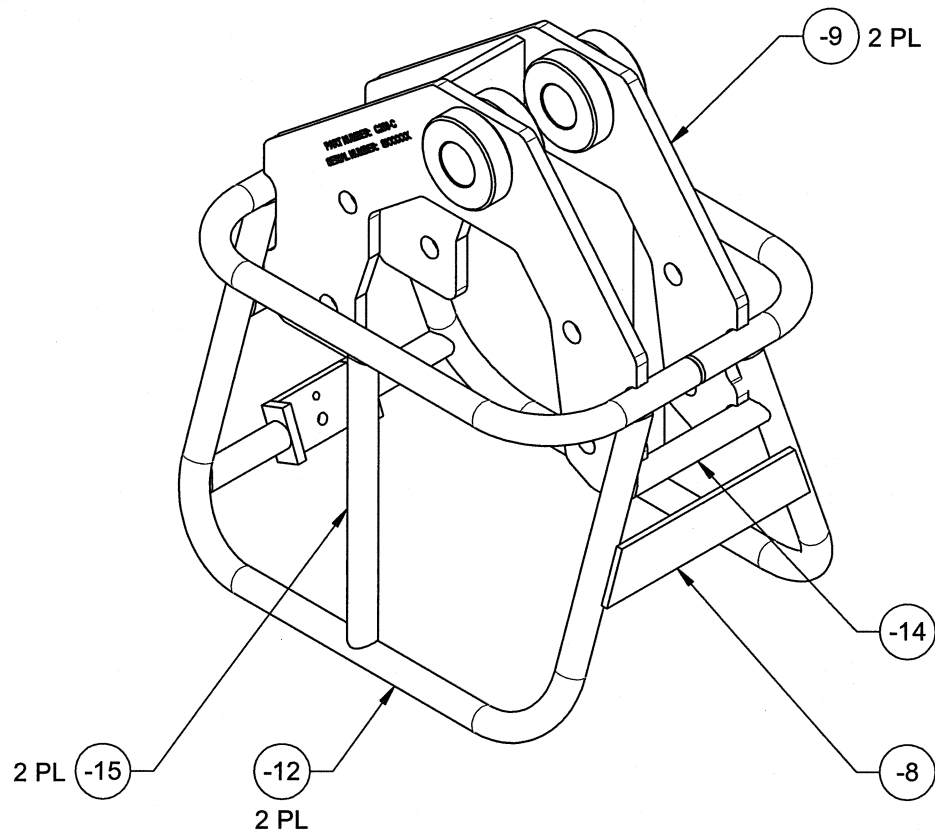
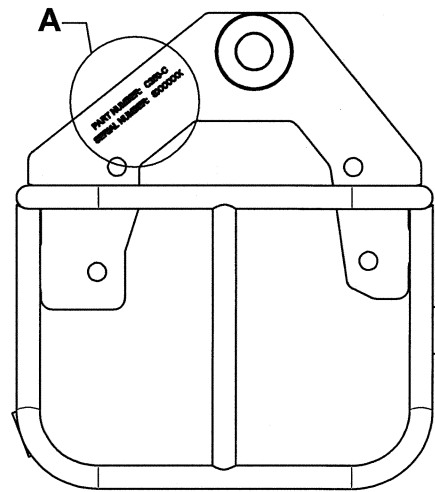
UNDER REVIEW
URF 19-891 19.09.09 (KT)

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. C
MFG. APPR.	DD	C250-C	SHEET 2 OF 22
APPROVED		TITLE	SCALE
		C250 CAGE ASSEMBLY	NTS 
DATE	2019-07-19	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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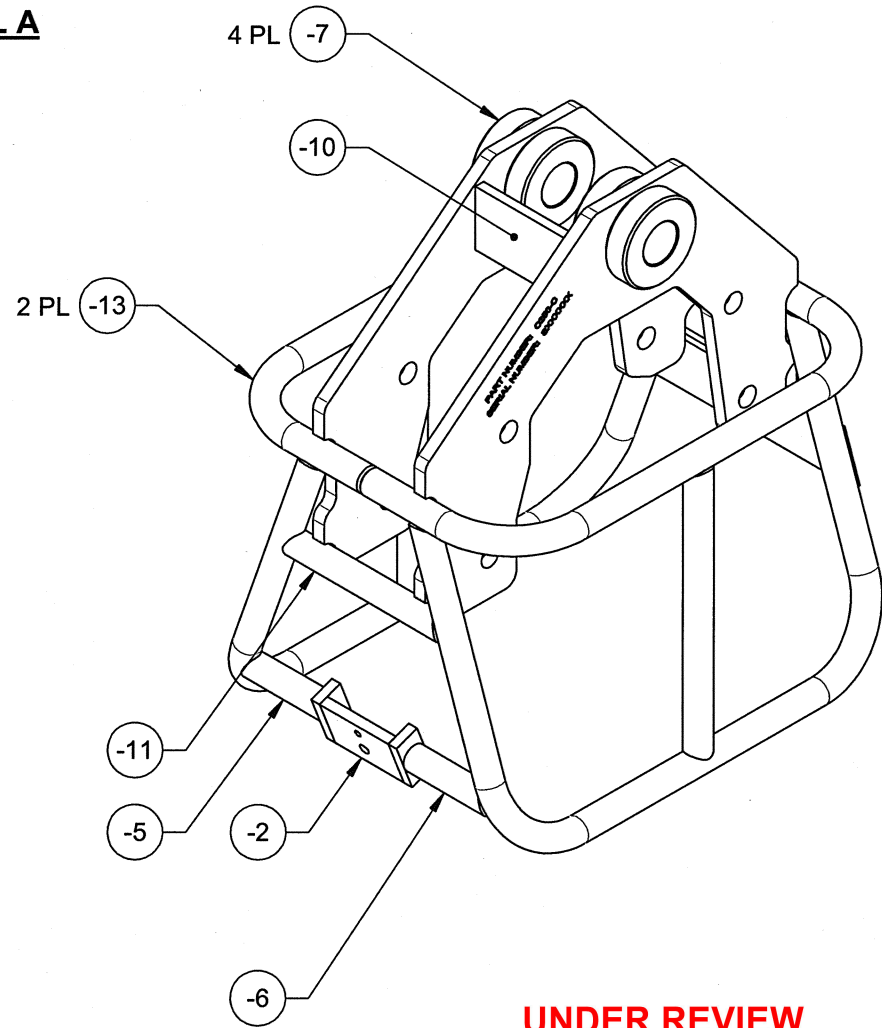
ITEM #	QTY	PART #	PART TITLE
-2	1	C250-C-2	BUMPER BRACKET WELDMENT
-5	1	C250-C-5	LEFT HAND BUMPER TUBE
-6	1	C250-C-6	RIGHT HAND BUMPER TUBE
-7	4	C250-C-7	CAGE BOSS
-8	1	C250-C-8	FRONT PLATE
-9	2	C250-C-9	LIFTING PLATE
-10	1	C250-C-10	LIMITING PLATE
-11	1	C250-C-11	MID TUBE
-12	2	C250-C-12	SIDE HOOP
-13	2	C250-C-13	TOP RING
-14	1	C250-C-14	TOP TUBE
-15	2	C250-C-15	SIDE TUBE



DETAIL A



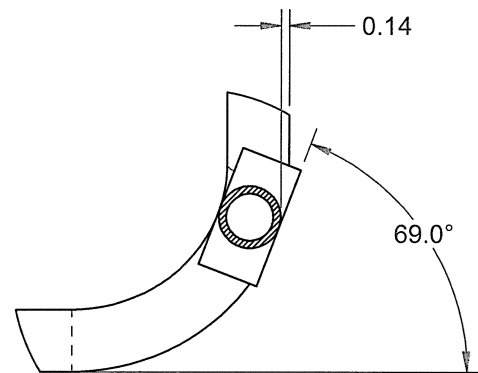
C250-C-1 C250 CAGE WELDMENT



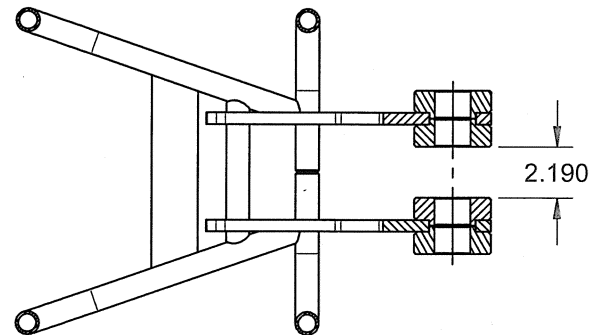
UNDER REVIEW
URF 19-891 19.09.09 (KT)

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: POWDERCOAT RED QSI 005 OR MIL-PRF-24712
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: INK STAMP T/N AND S/N PER QSI 044 AFTER POWDERCOAT
 - 7) ASSEMBLE AS SHOWN
 - 8) REMOVE ALL WELD SPATTERS
 - 9) NOTCH ENDS OF ITEMS -5, -6, -11, -12, -14, AND -15 AS REQUIRED, PRIOR TO WELDING

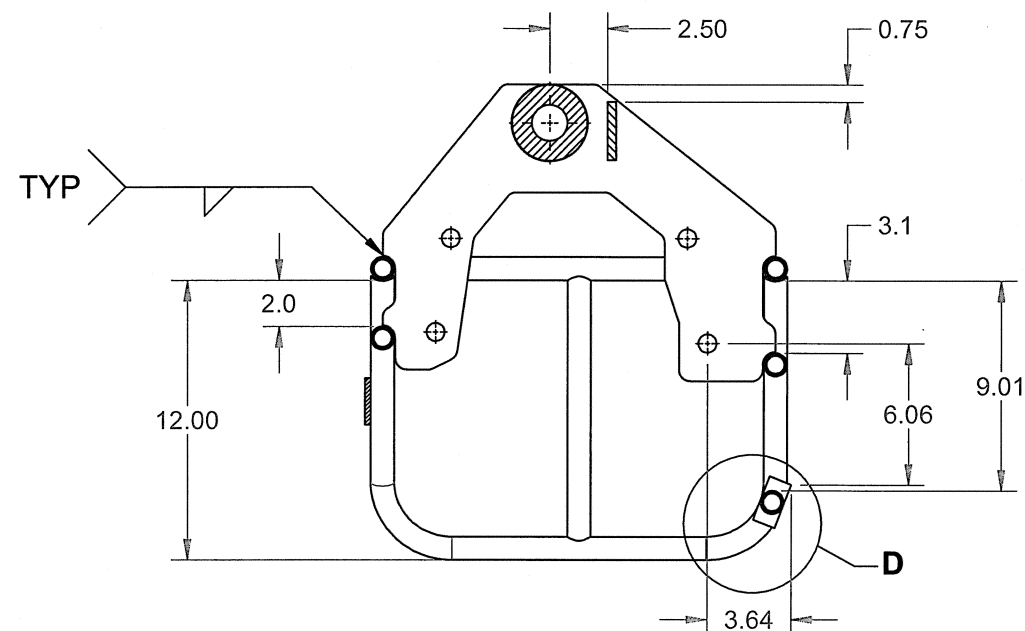
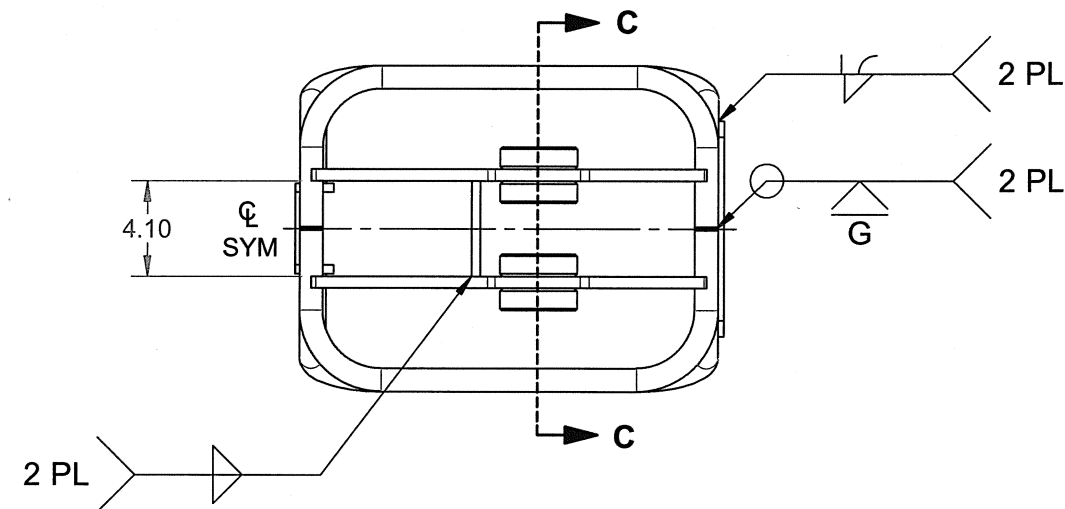
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DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. C
MFG. APPR.	DD	C250-C	SHEET 3 OF 22
APPROVED	WJP	TITLE	SCALE
		C250 CAGE ASSEMBLY	NTS
DATE	2019-07-19	COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



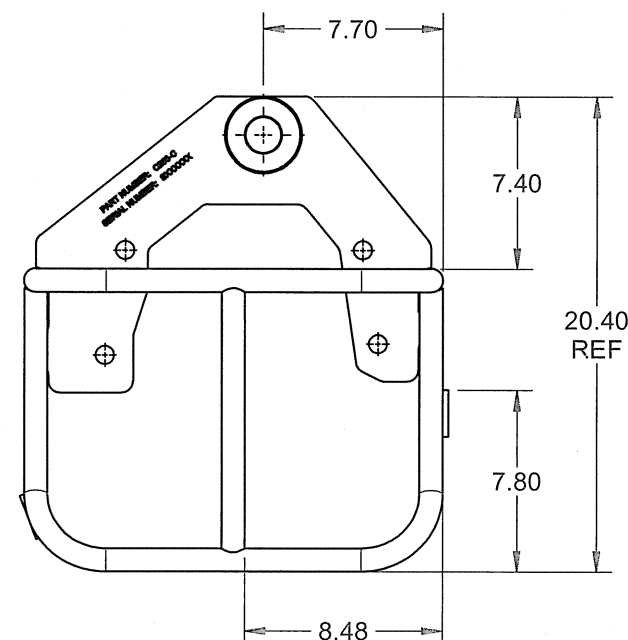
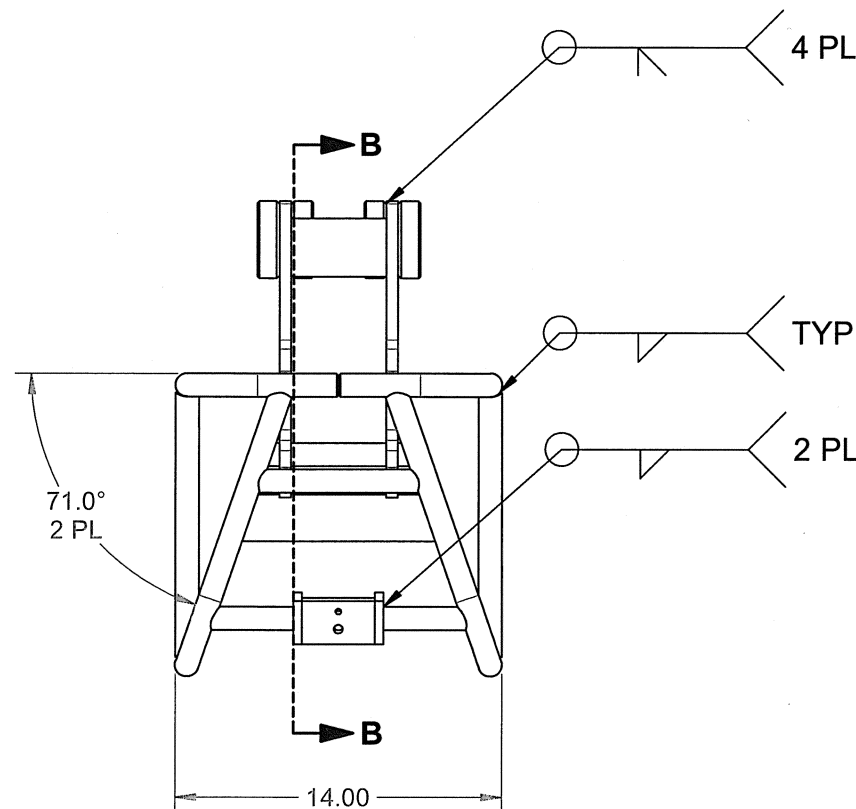
DETAIL D



SECTION C-C



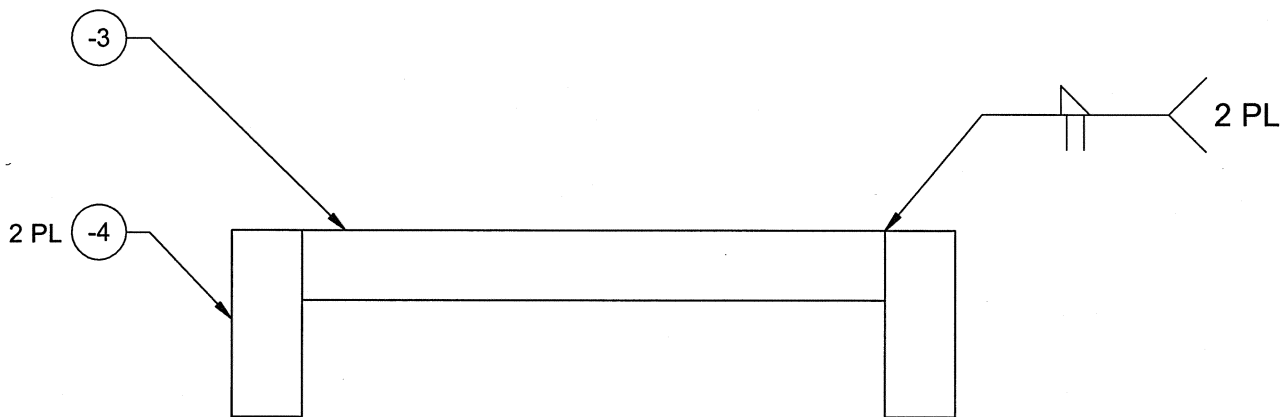
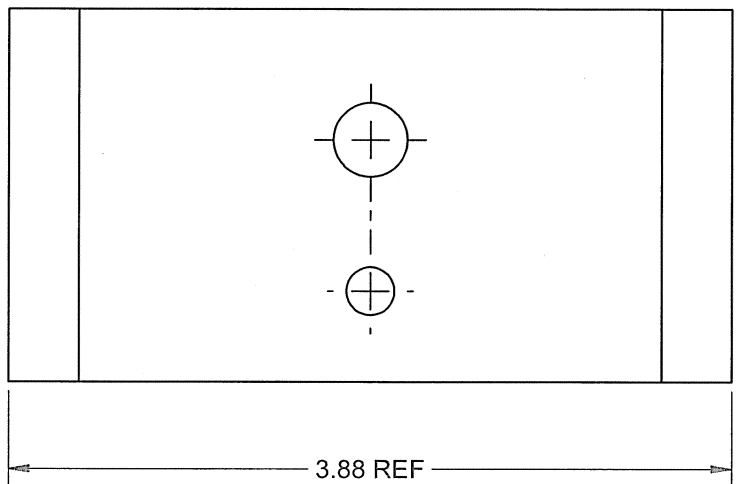
SECTION B-B



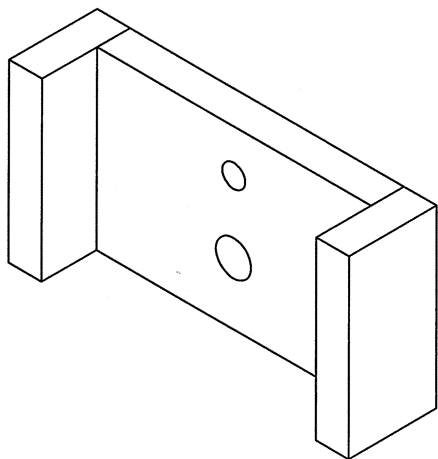
UNDER REVIEW
URF 19-891 19.09.09 (KT)

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. C
MFG. APPR.	DD	C250-C	SHEET 4 OF 22
APPROVED	<i>[Signature]</i>	TITLE	SCALE
		C250 CAGE ASSEMBLY	NTS
DATE	2019-07-19	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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ITEM #	QTY	PART #	PART TITLE
-3	1	C250-C-3	FRONT PLATE BUMPER BRACKET
-4	2	C250-C-4	SIDE PLATE BUMPER BRACKET



C250-C-2 BUMPER BRACKET WELDMENT



- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) REMOVE ALL WELD SPATTERS

UNDER REVIEW
URF 19-891 19.09.09 (KT)

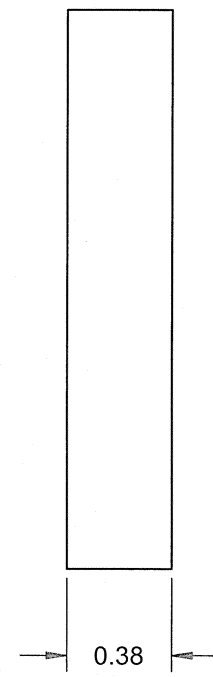
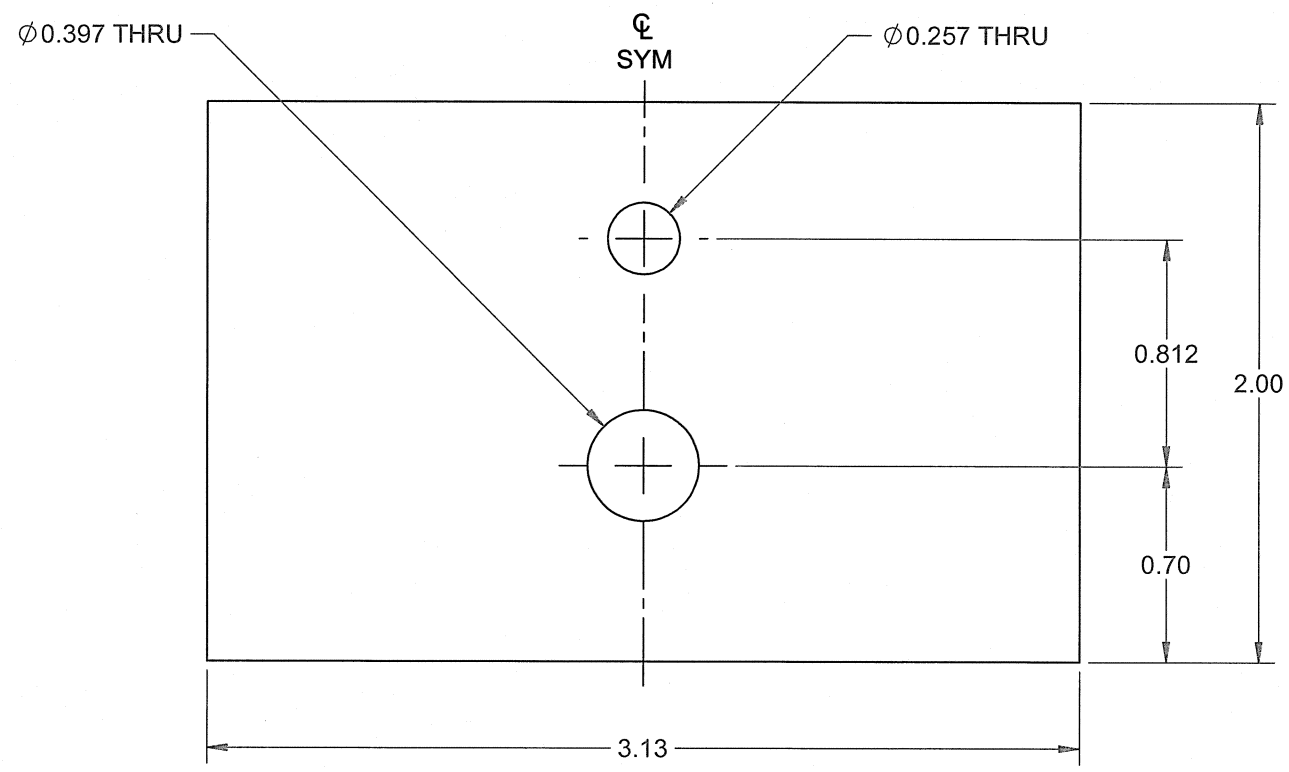
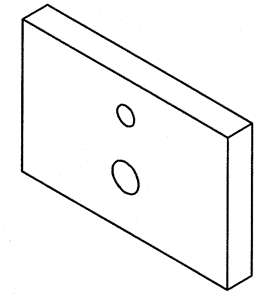
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DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. C
MFG. APPR.	DD	C250-C	SHEET 5 OF 22
APPROVED		TITLE	SCALE
DATE	2019-07-19	C250 CAGE ASSEMBLY	NTS
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C250-C-3 FRONT PLATE BUMPER BRACKET

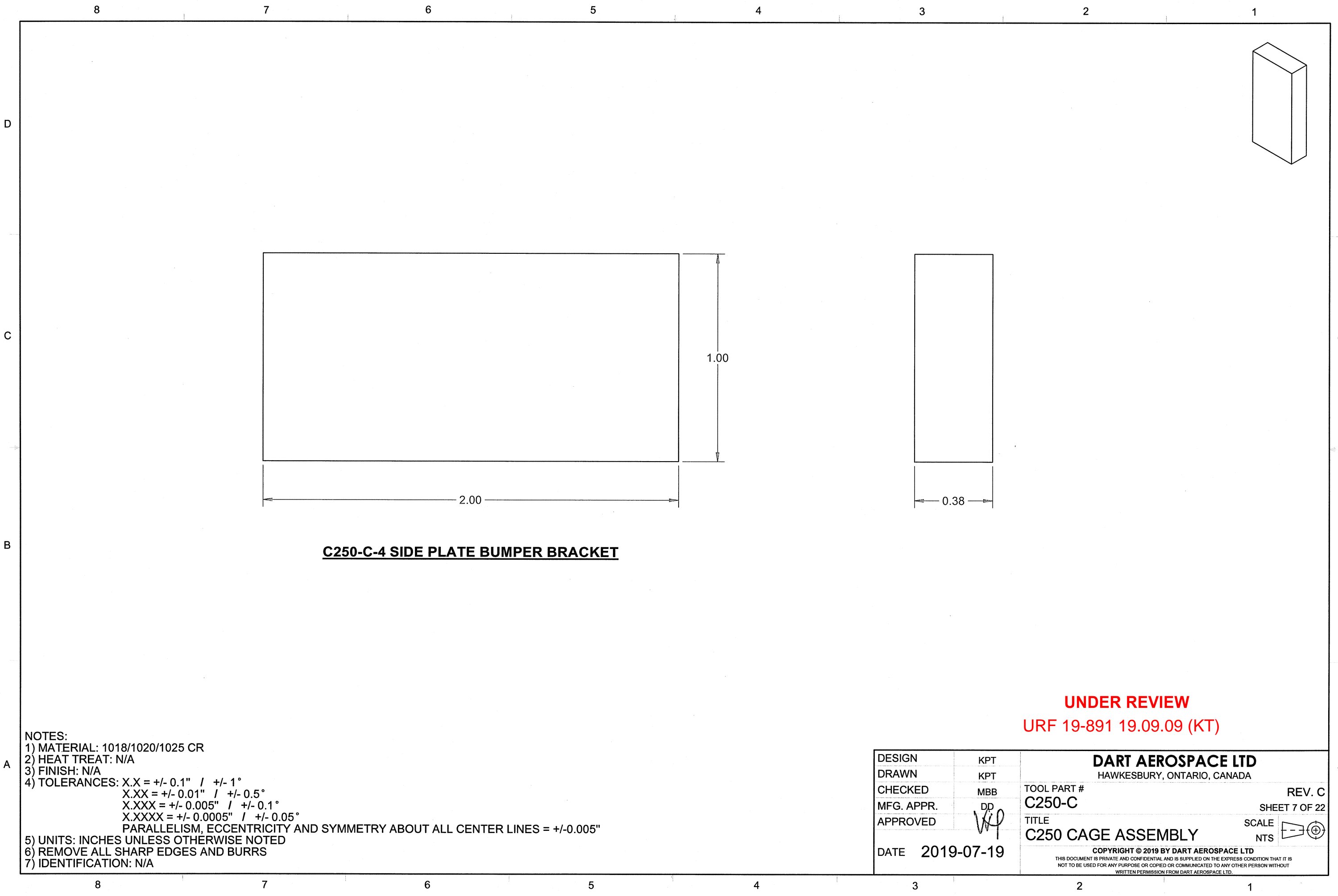
UNDER REVIEW
URF 19-891 19.09.09 (KT)

- NOTES:
- 1) MATERIAL: 1018/1020/1025 CR
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. C
MFG. APPR.	DD	C250-C	SHEET 6 OF 22
APPROVED		TITLE	SCALE
		C250 CAGE ASSEMBLY	NTS
DATE	2019-07-19	COPYRIGHT © 2019 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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C250-C-4 SIDE PLATE BUMPER BRACKET

UNDER REVIEW
URF 19-891 19.09.09 (KT)

- NOTES:
- 1) MATERIAL: 1018/1020/1025 CR
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. C
MFG. APPR.	DD	C250-C	SHEET 7 OF 22
APPROVED		TITLE	SCALE
		C250 CAGE ASSEMBLY	NTS
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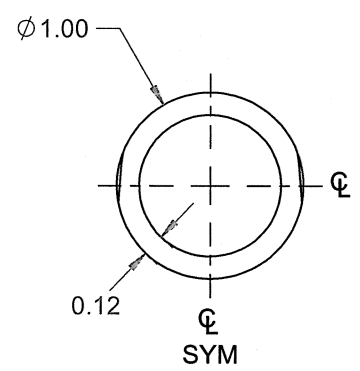
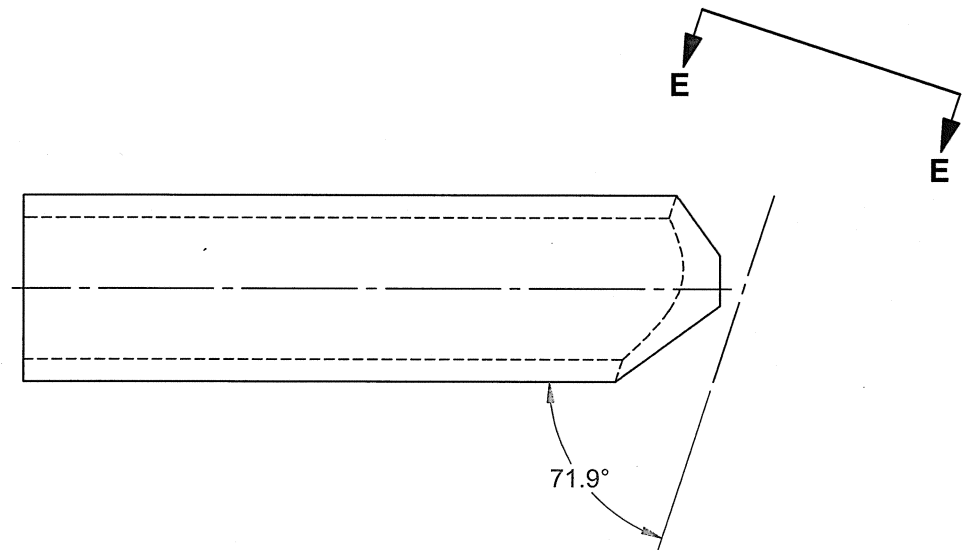
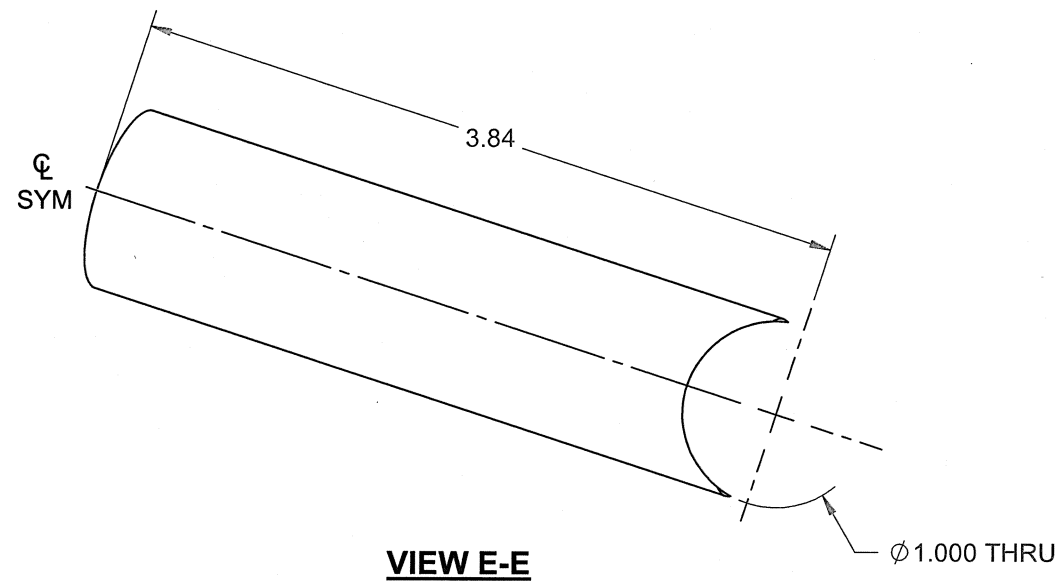
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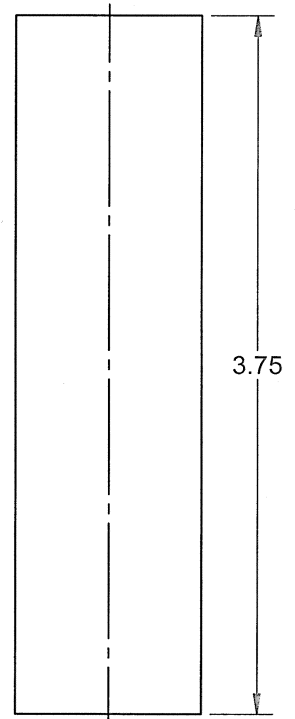
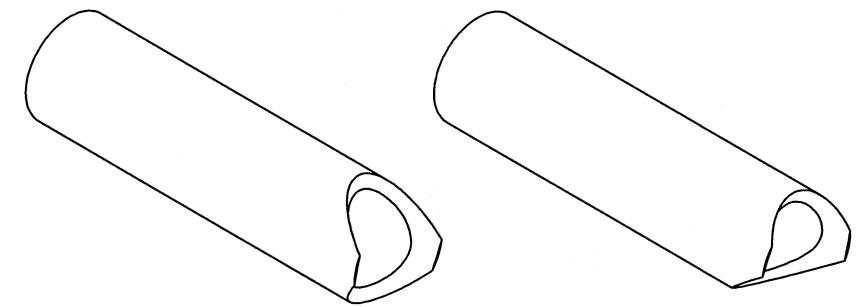
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C250-C-5 LEFT HAND BUMPER TUBE

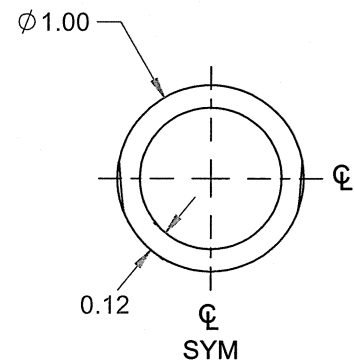
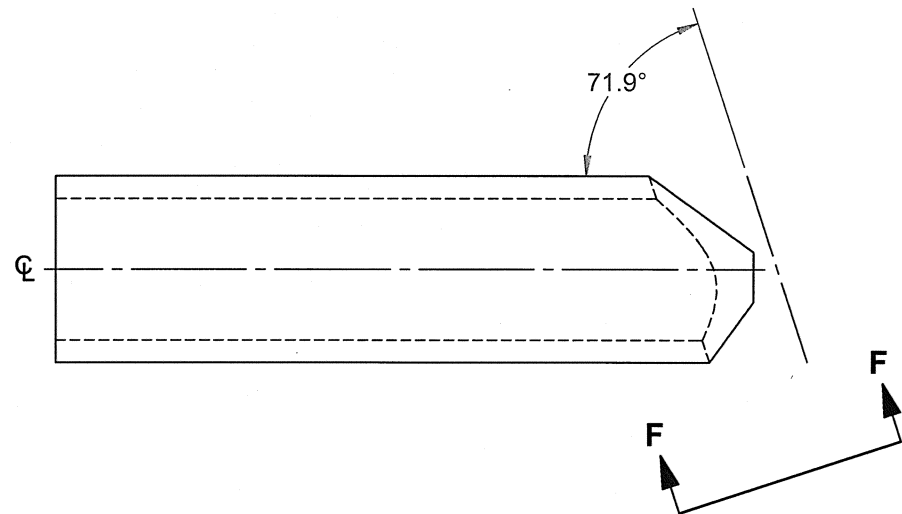


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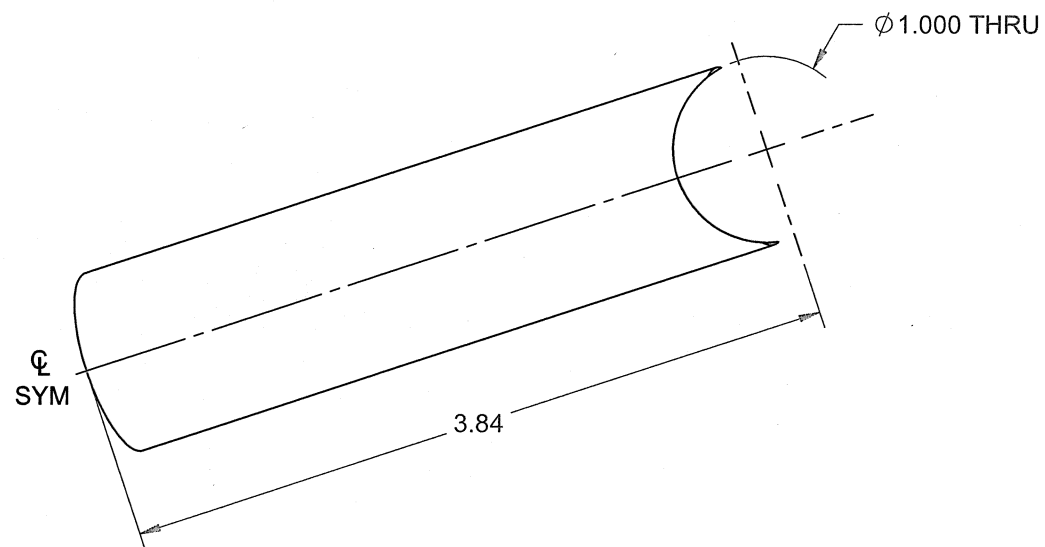
UNDER REVIEW
URF 19-891 19.09.09 (KT)

- NOTES:
- 1) MATERIAL: A513 TYPE 5 DOM TUBING
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

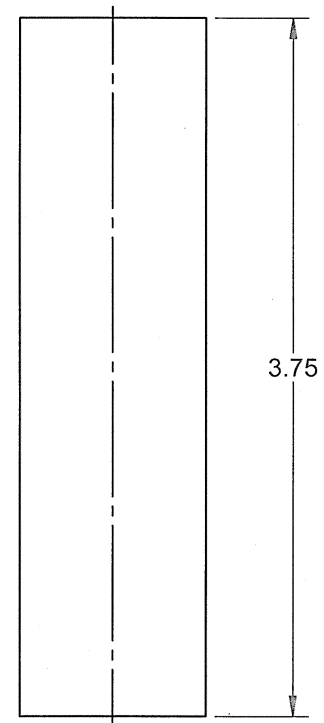
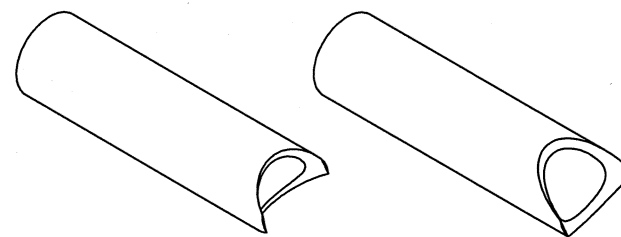
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. C
MFG. APPR.	DD	C250-C	SHEET 8 OF 22
APPROVED		TITLE	SCALE
		C250 CAGE ASSEMBLY	NTS
DATE	2019-07-19	COPYRIGHT © 2019 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



C250-C-6 RIGHT HAND BUMPER TUBE



VIEW F-F



STOCK

UNDER REVIEW
URF 19-891 19.09.09 (KT)

- NOTES:
- 1) MATERIAL: A513 TYPE 5 DOM TUBING
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. C
MFG. APPR.	DD	C250-C	SHEET 9 OF 22
APPROVED	<i>WHP</i>	TITLE	SCALE
		C250 CAGE ASSEMBLY	NTS
DATE	2019-07-19	COPYRIGHT © 2019 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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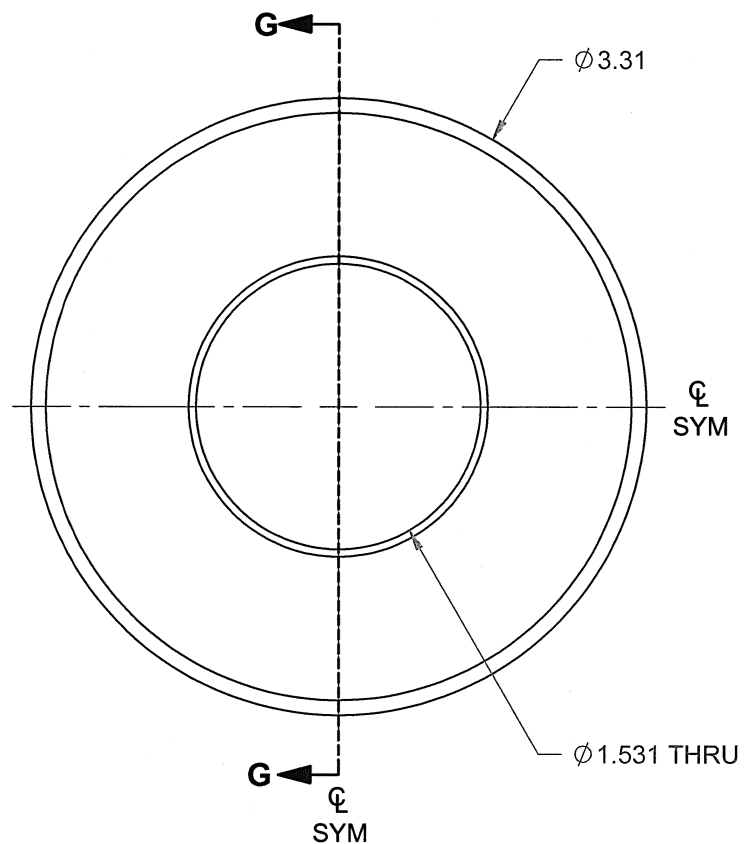
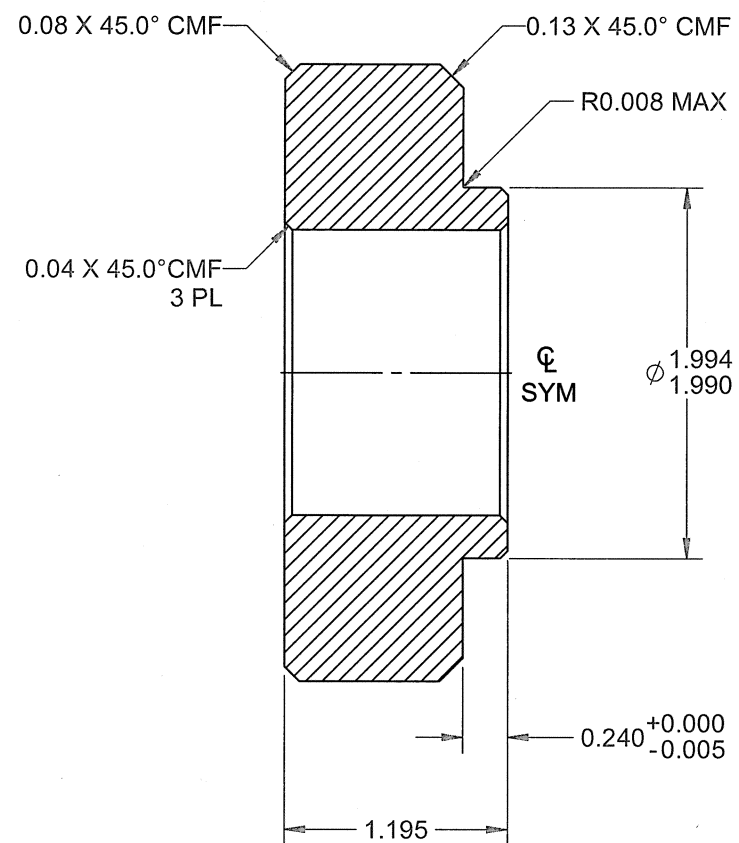
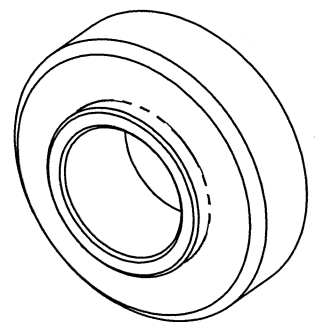
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C

B

A

**C250-C-7 CAGE BOSS****SECTION G-G**

D

C

B

A

NOTES:

1) MATERIAL: 1018/1020/1025 CR

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°



PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

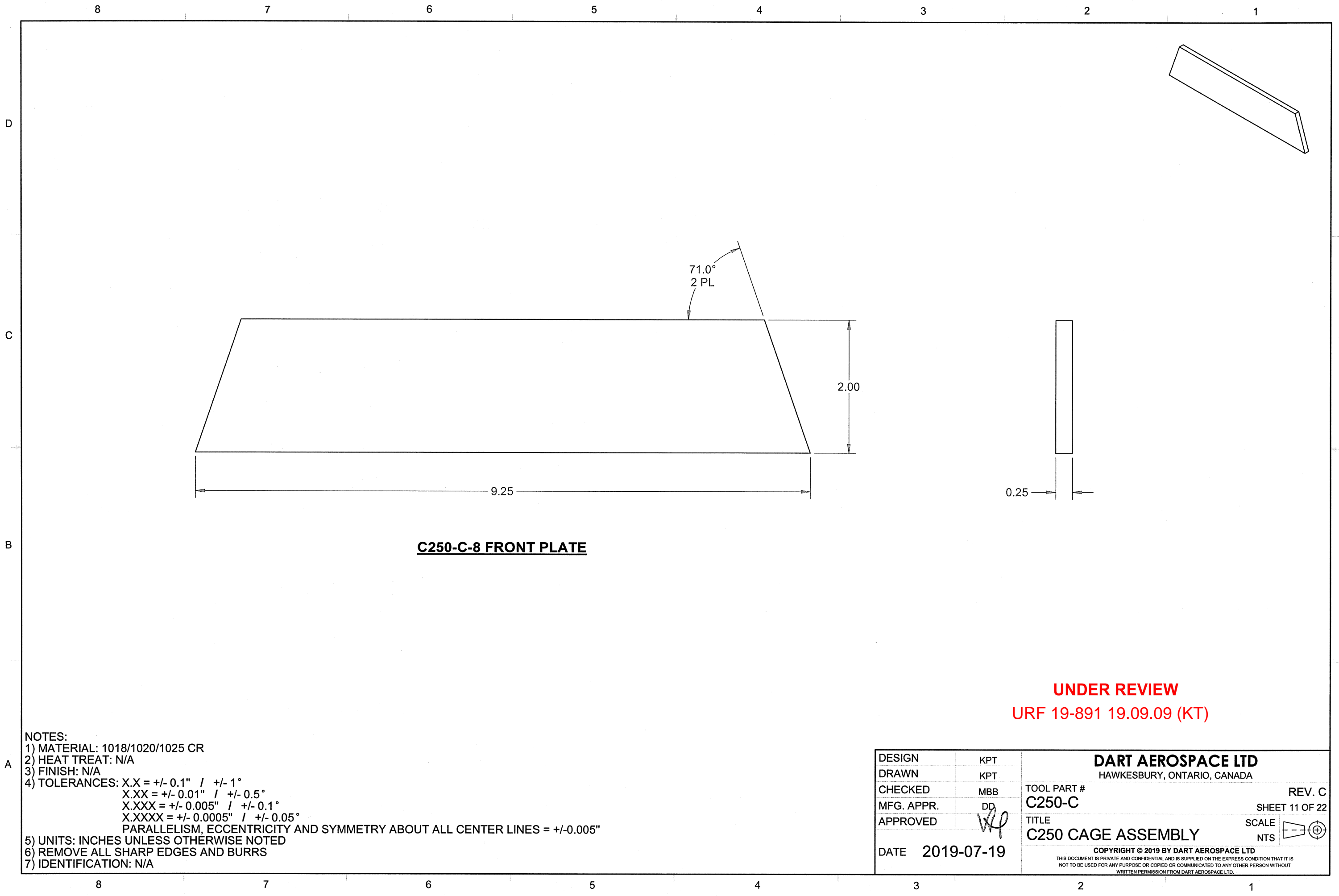
5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

UNDER REVIEW**URF 19-891 19.09.09 (KT)**

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. C
MFG. APPR.	DD	C250-C	SHEET 10 OF 22
APPROVED		TITLE	SCALE
		C250 CAGE ASSEMBLY	NTS 
DATE	2019-07-19	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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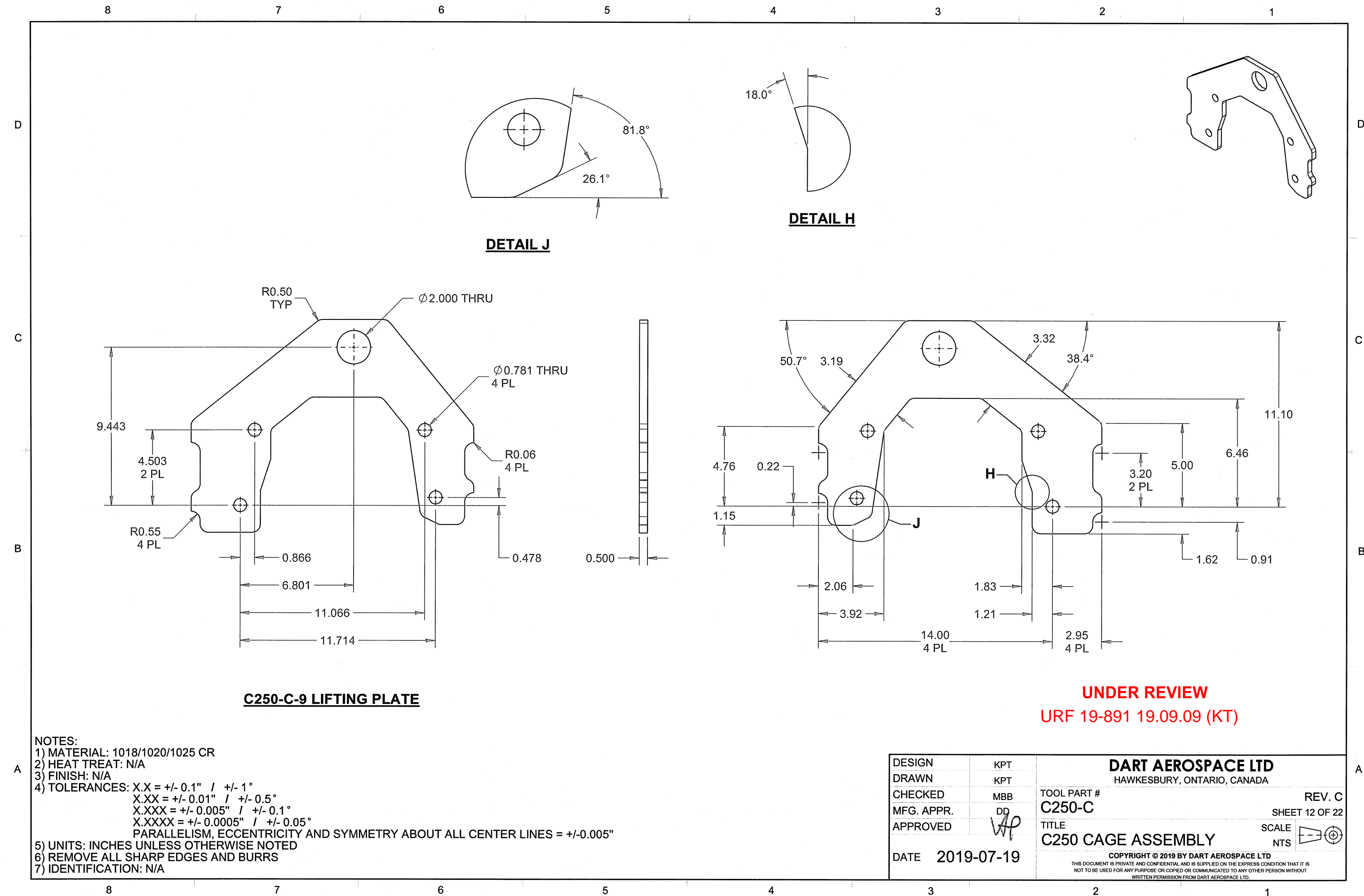


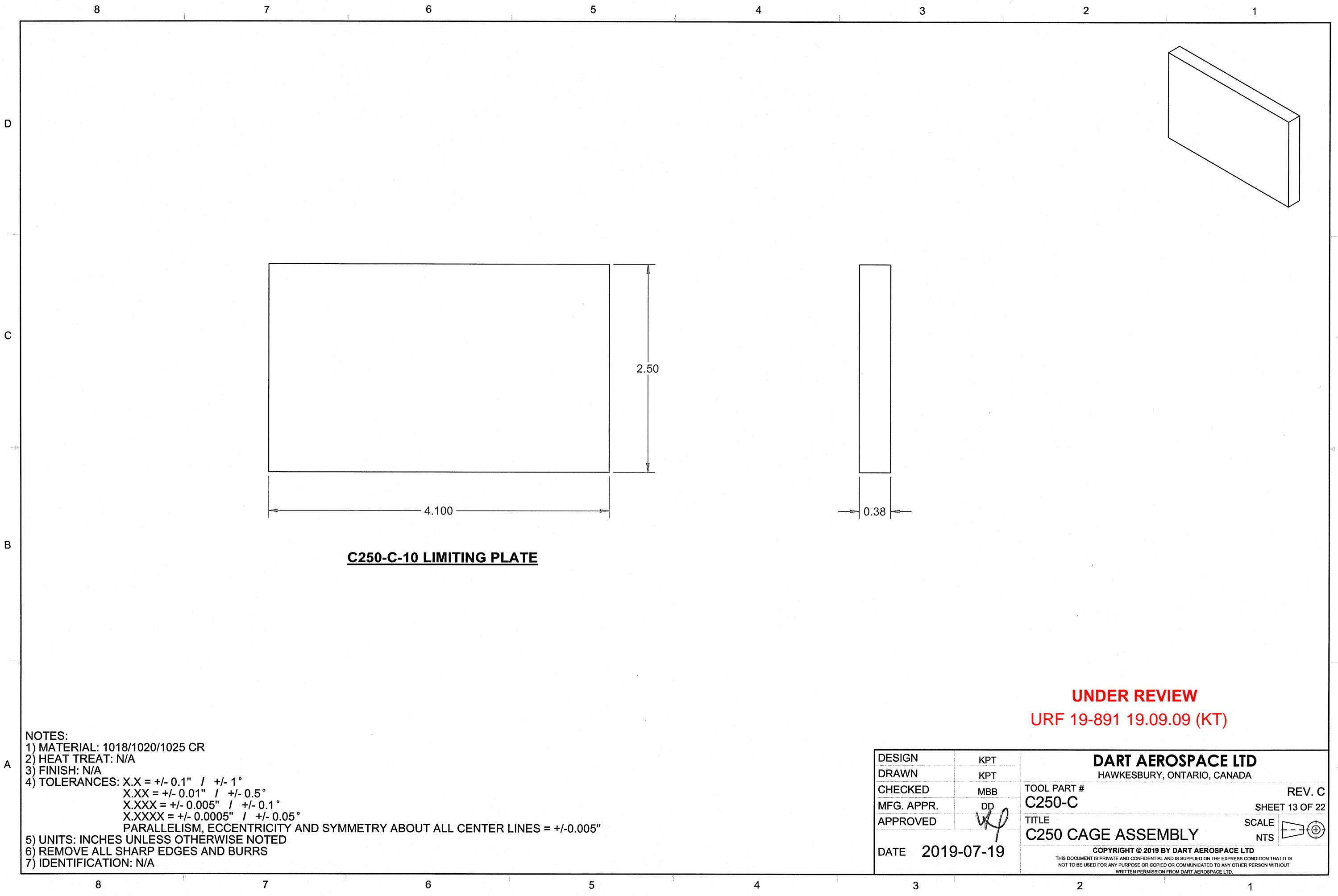
C250-C-8 FRONT PLATE

UNDER REVIEW
URF 19-891 19.09.09 (KT)

NOTES:
1) MATERIAL: 1018/1020/1025 CR
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. C
MFG. APPR.	DD	C250-C	SHEET 11 OF 22
APPROVED	<i>[Signature]</i>	TITLE	SCALE
		C250 CAGE ASSEMBLY	NTS
DATE	2019-07-19	COPYRIGHT © 2019 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	





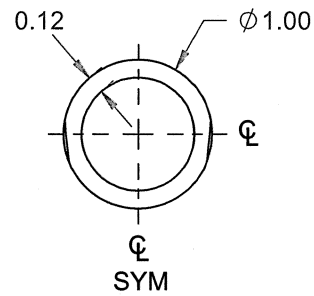


C250-C-10 LIMITING PLATE

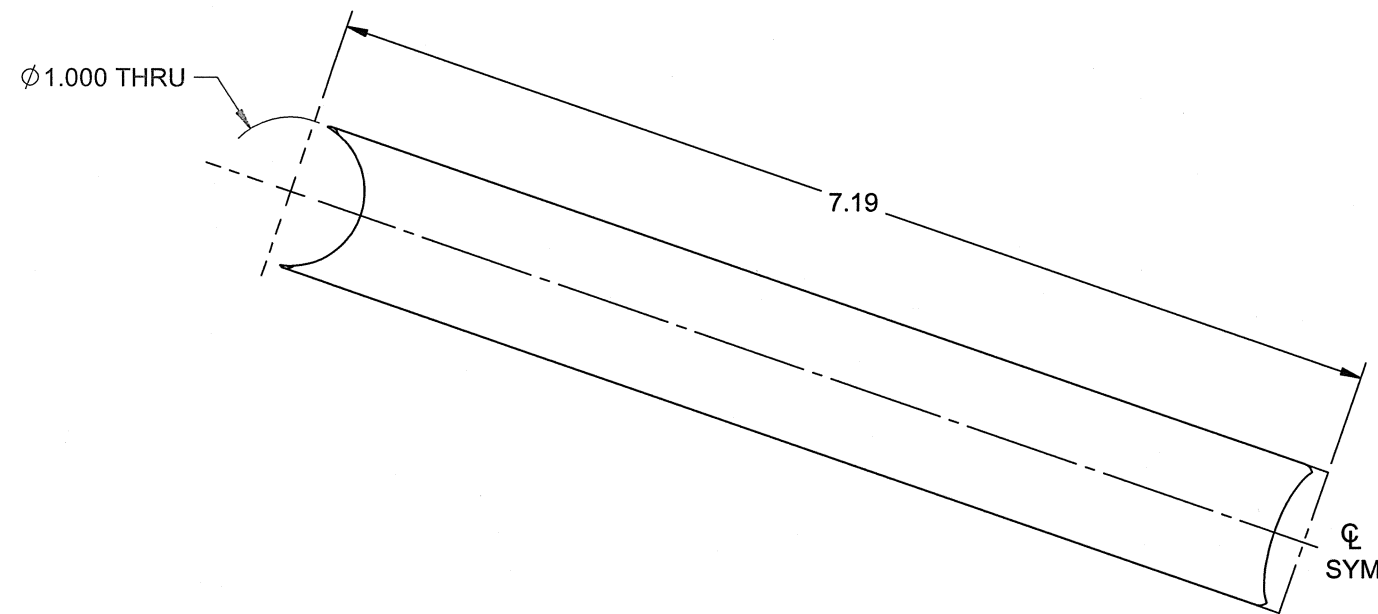
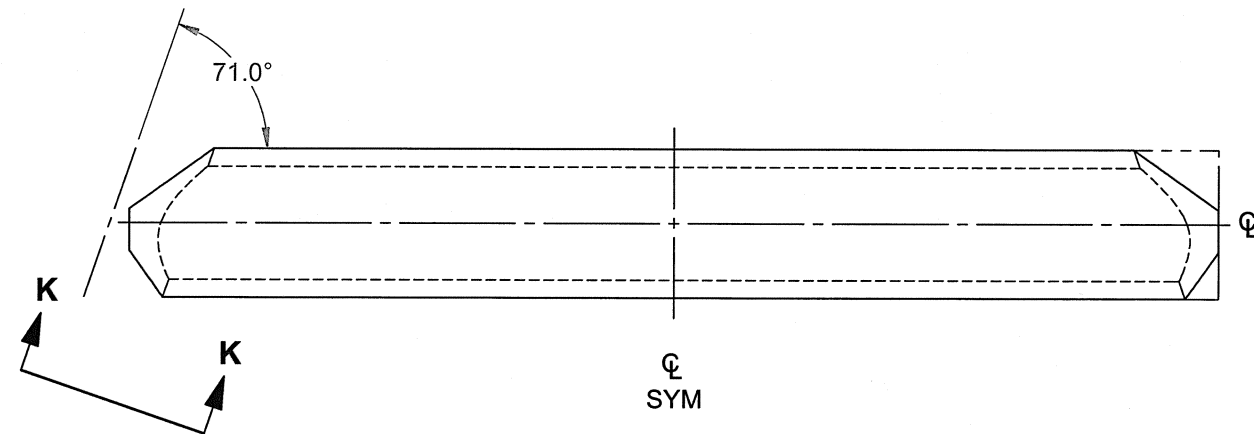
UNDER REVIEW
URF 19-891 19.09.09 (KT)

- NOTES:
- 1) MATERIAL: 1018/1020/1025 CR
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

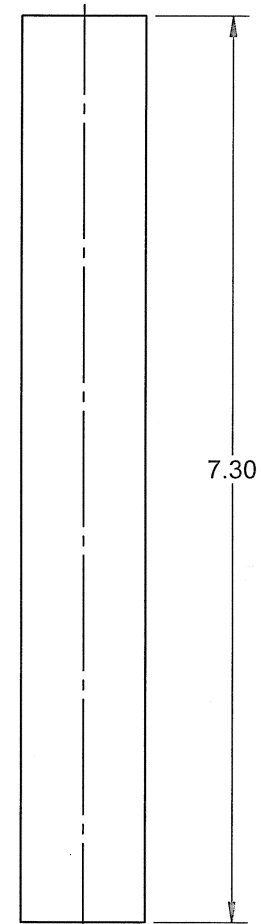
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. C
MFG. APPR.	DD	C250-C	SHEET 13 OF 22
APPROVED		TITLE	SCALE
DATE 2019-07-19		C250 CAGE ASSEMBLY	NTS 
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C250-C-11 MID TUBE



VIEW K-K
2 PL



STOCK

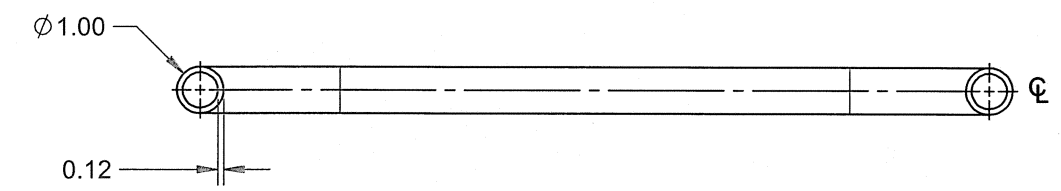
UNDER REVIEW
URF 19-891 19.09.09 (KT)

- NOTES:
- 1) MATERIAL: A513 TYPE 5 DOM TUBING
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

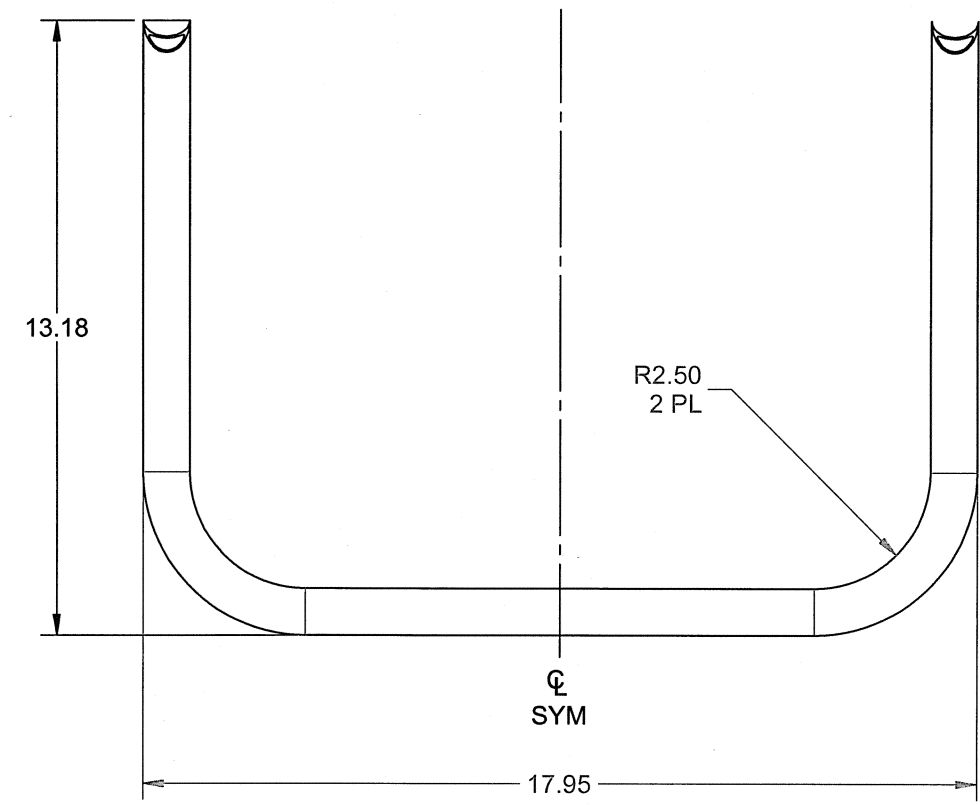
DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. C
MFG. APPR.	DD	C250-C	SHEET 14 OF 22
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE	2019-07-19	C250 CAGE ASSEMBLY	NTS
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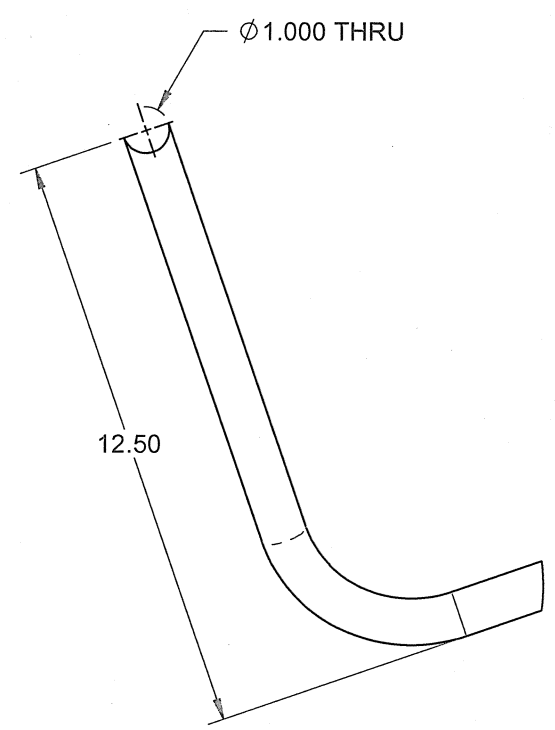
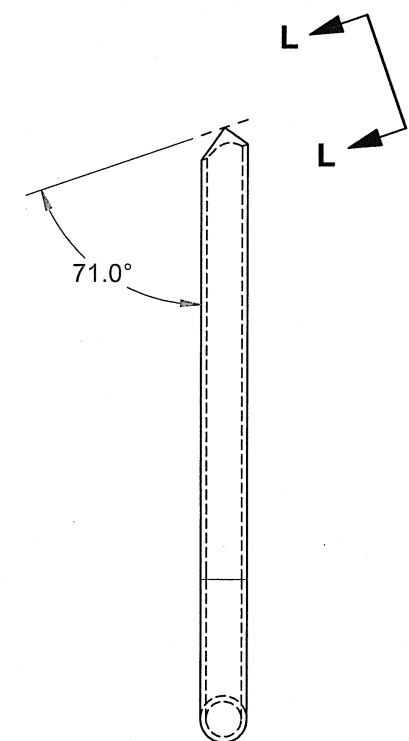
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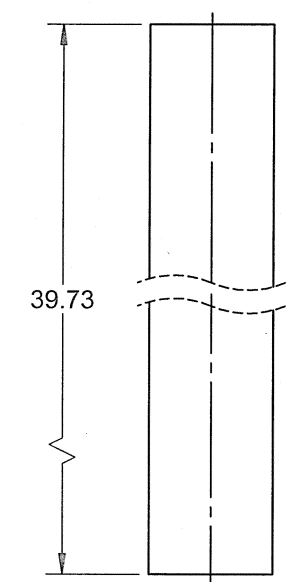
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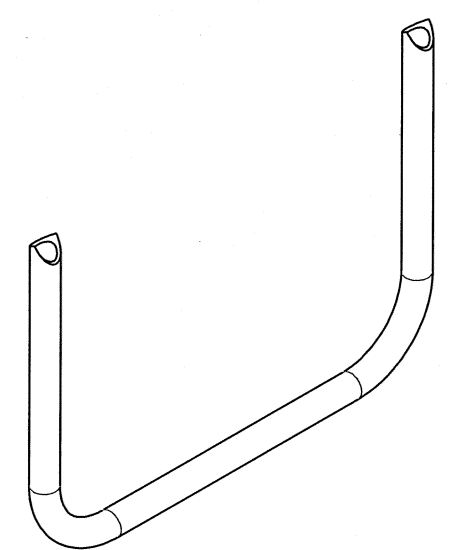
C250-C-12 SIDE HOOP



VIEW L-L
2 PL





STOCK



UNDER REVIEW
URF 19-891 19.09.09 (KT)

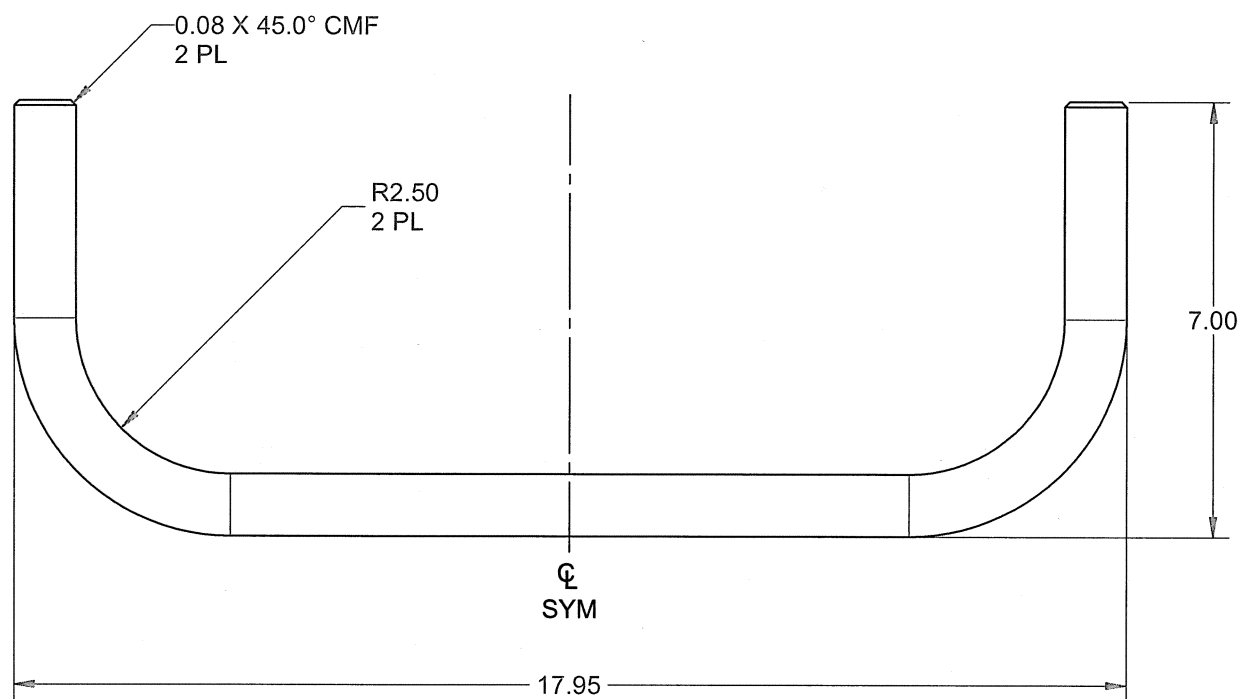
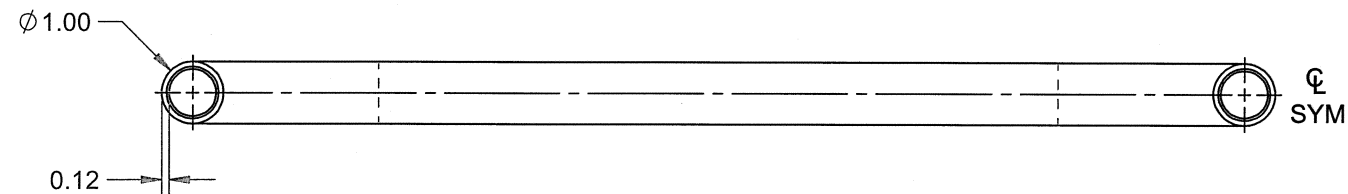
- NOTES:
- 1) MATERIAL: A513 TYPE 5 DOM TUBING
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. C
MFG. APPR.	DD	C250-C	SHEET 15 OF 22
APPROVED		TITLE	SCALE
		C250 CAGE ASSEMBLY	NTS 
DATE	2019-07-19	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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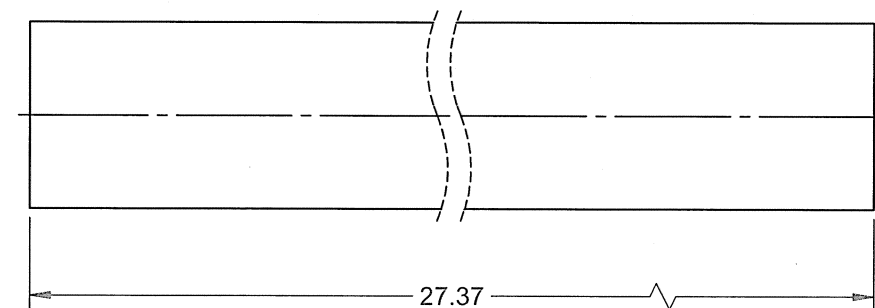
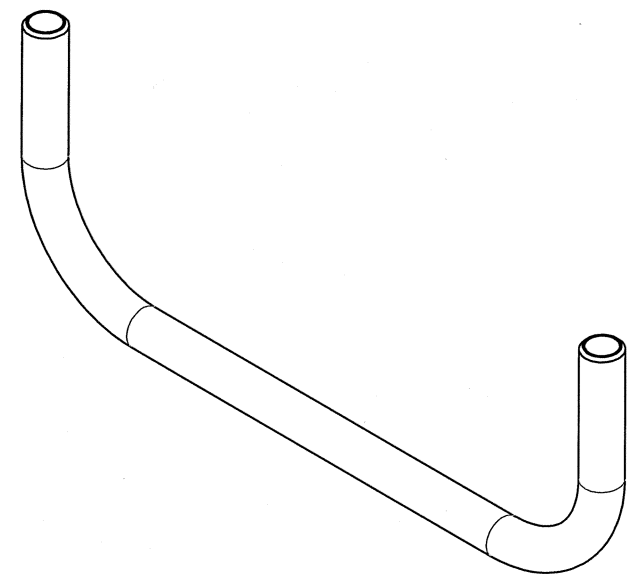
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A

8 7 6 5 4 3 2 1





C250-C-13 TOP RING

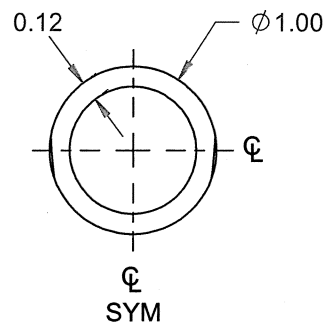


STOCK

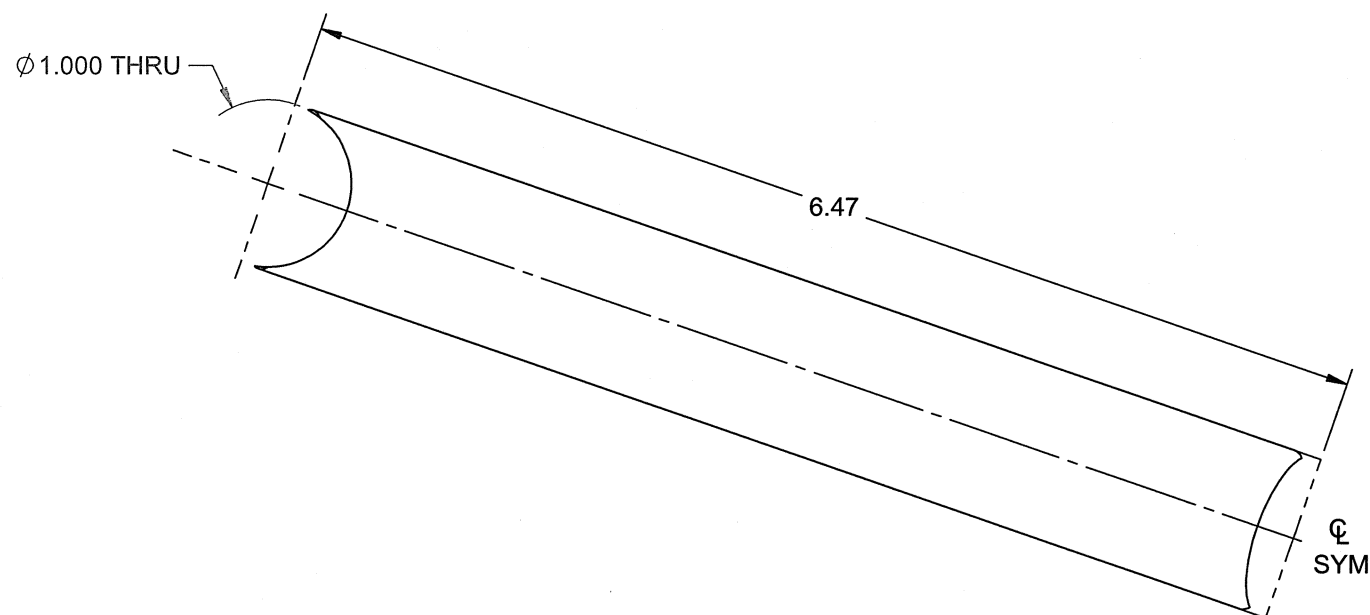
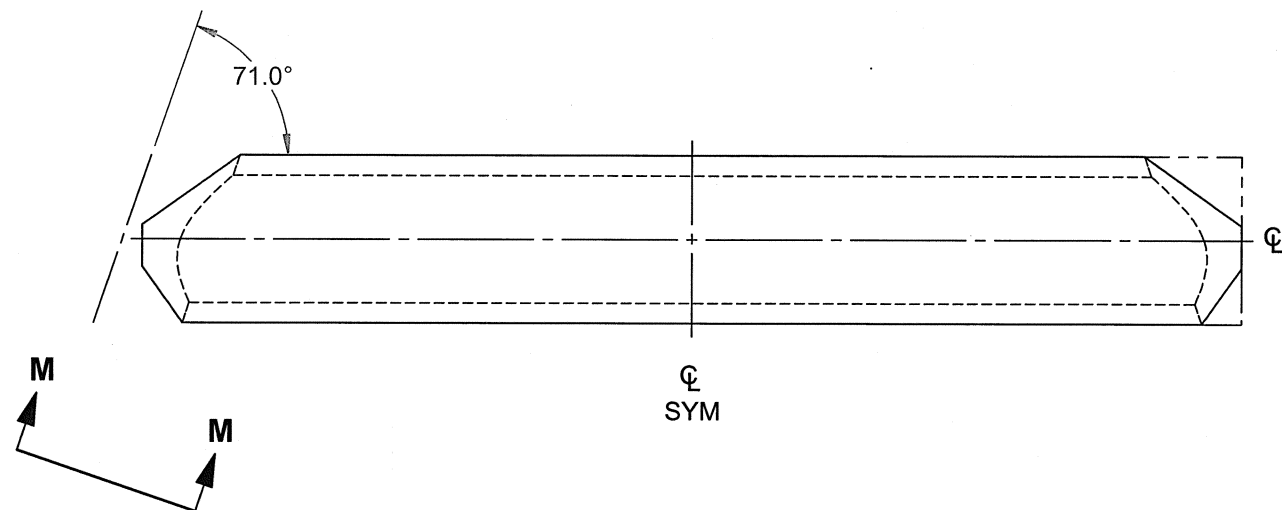
UNDER REVIEW
URF 19-891 19.09.09 (KT)

- NOTES:
- 1) MATERIAL: A513 TYPE 5 DOM TUBING
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

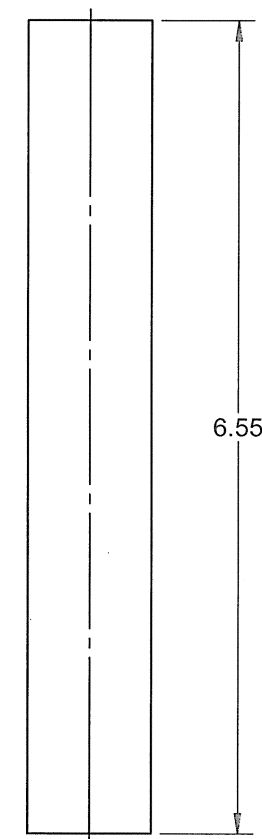
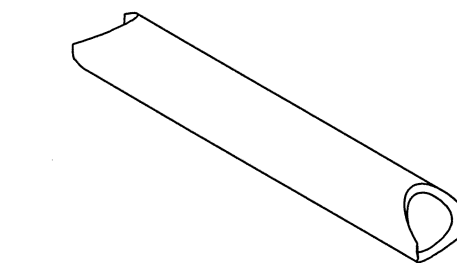
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. C
MFG. APPR.	DD	C250-C	SHEET 16 OF 22
APPROVED		TITLE	SCALE
DATE	2019-07-19	C250 CAGE ASSEMBLY	NTS 
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C250-C-14 TOP TUBE



VIEW M-M
2 PL

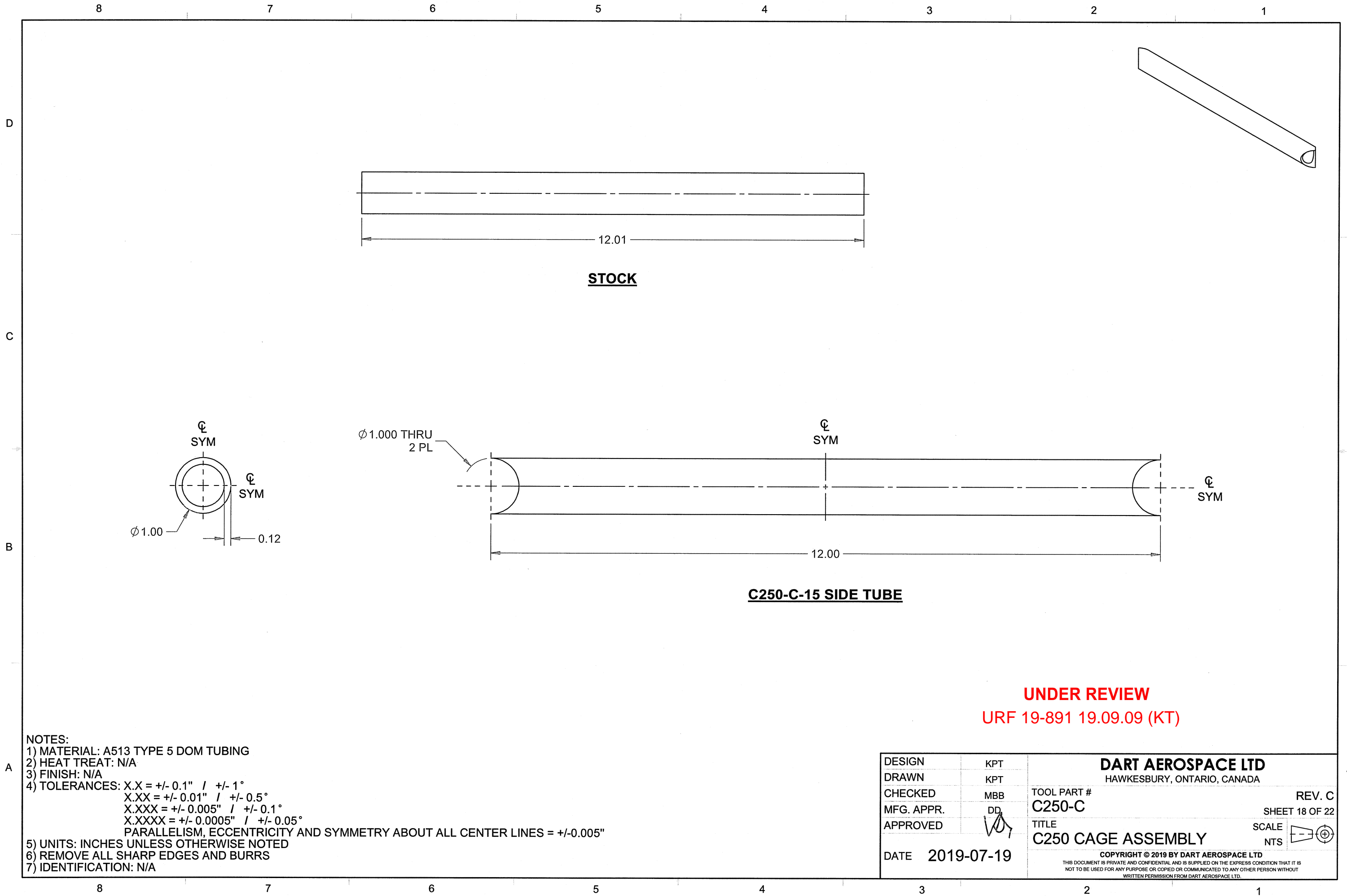


STOCK

- NOTES:
- 1) MATERIAL: A513 TYPE 5 DOM TUBING
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

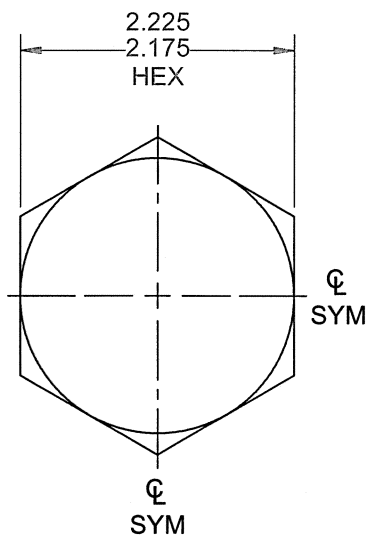
UNDER REVIEW
URF 19-891 19.09.09 (KT)

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. C
MFG. APPR.	DD	C250-C	SHEET 17 OF 22
APPROVED		TITLE	SCALE
		C250 CAGE ASSEMBLY	NTS
DATE	2019-07-19	COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



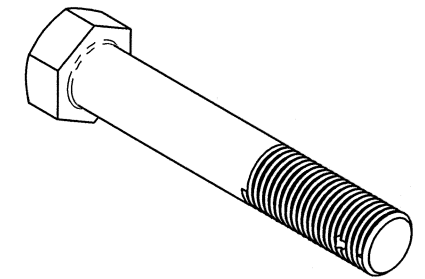
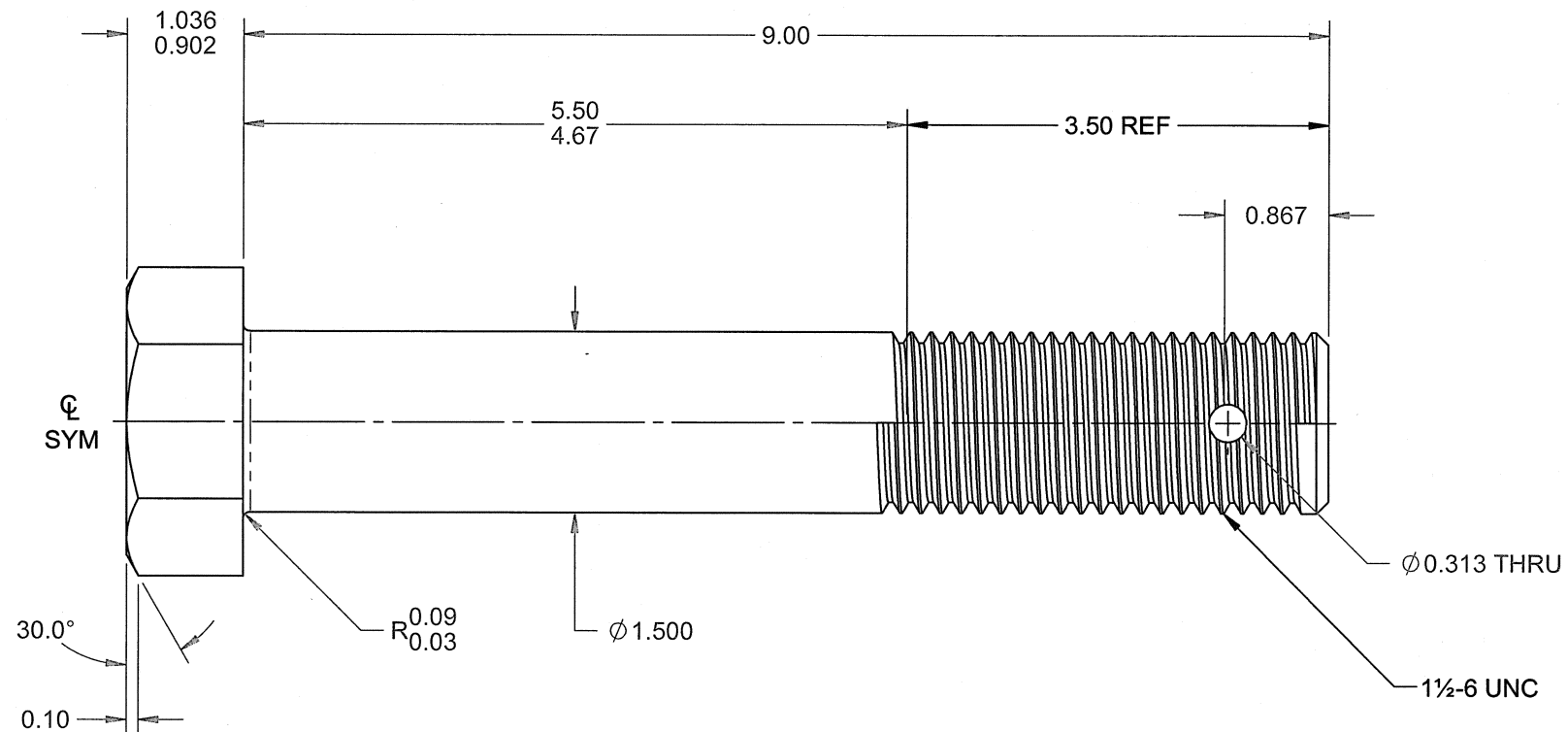
- NOTES:
- 1) MATERIAL: A513 TYPE 5 DOM TUBING
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. C
MFG. APPR.	DD	C250-C	SHEET 18 OF 22
APPROVED		TITLE	SCALE
		C250 CAGE ASSEMBLY	NTS
DATE	2019-07-19	COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



C250-C-16 LIFTING BOLT



8



NOTES:

- 1) MATERIAL: SEE NOTE 8
- 2) HEAT TREAT: SEE NOTE 8
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) LIFTING BOLT MUST CONFORM TO ASTM A354 (GRADE BD)

UNDER REVIEW
URF 19-891 19.09.09 (KT)

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. C
MFG. APPR.	DD	C250-C	SHEET 19 OF 22
APPROVED		TITLE	SCALE
		C250 CAGE ASSEMBLY	NTS 
DATE	2019-07-19	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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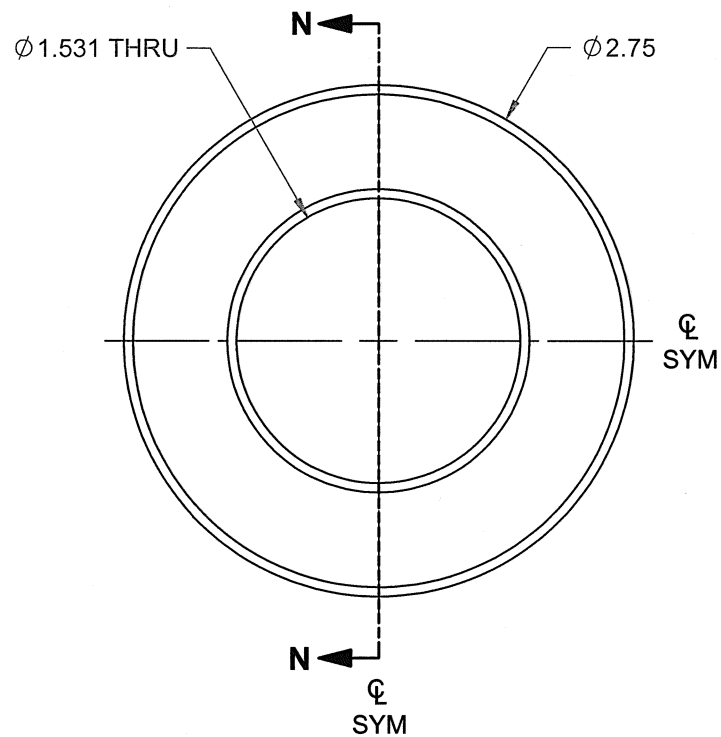
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D

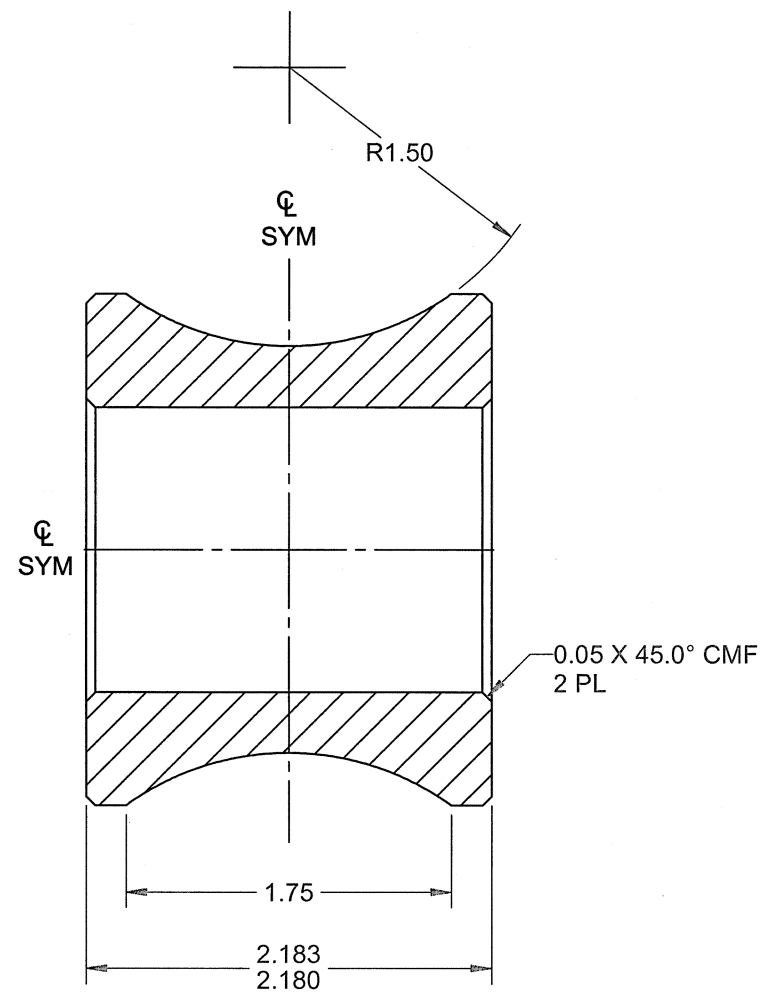
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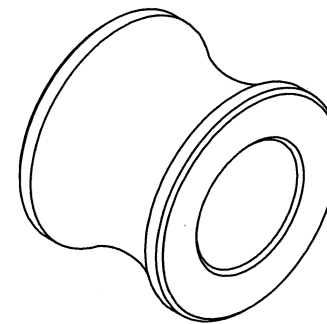
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C250-C-17 LIFTING BUSHING



SECTION N-N



D

C


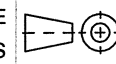
B

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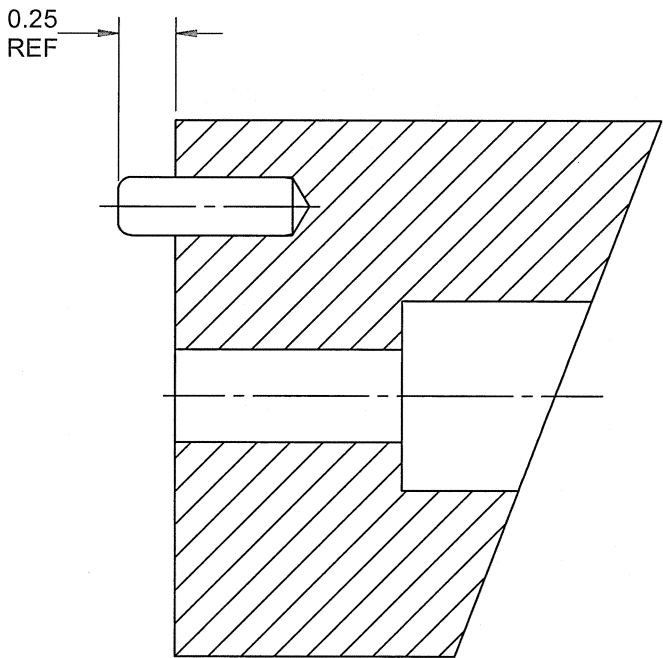
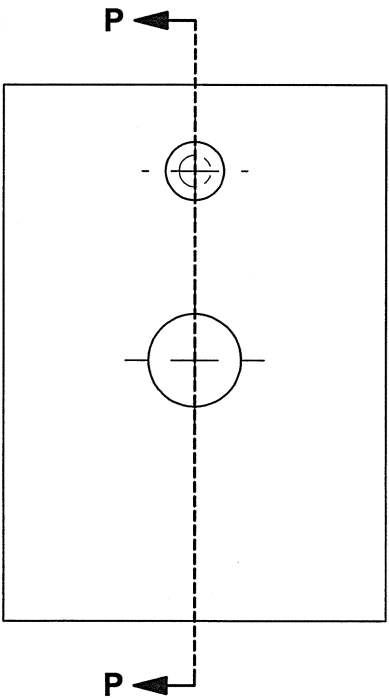
NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: NICKEL PLATE PER MIL-C-26074 CLASS 2 GRADE B OR QQ-N-290A CLASS 2 GRADE E
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

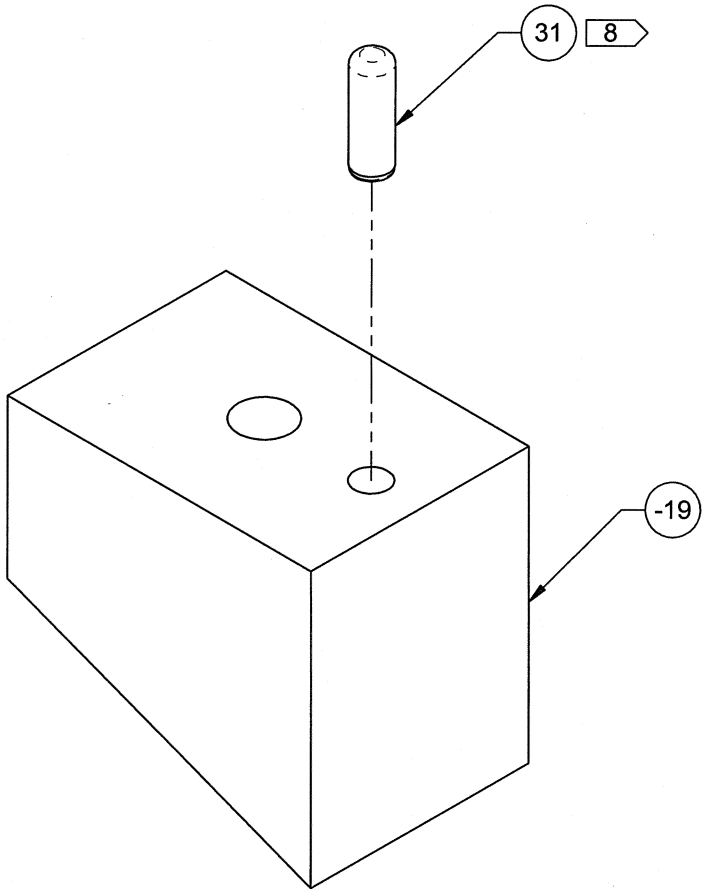
UNDER REVIEW
URF 19-891 19.09.09 (KT)

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. C
MFG. APPR.	DD	C250-C	SHEET 20 OF 22
APPROVED		TITLE	SCALE
DATE	2019-08-20	C250 CAGE ASSEMBLY	NTS 
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ITEM #	QTY	PART #	PART TITLE
-19	1	C250-C-19	BUMPER
31	1	MS16555-646	SS DOWEL PIN 1/4" DIA. X 3/4" LG.



SECTION P-P

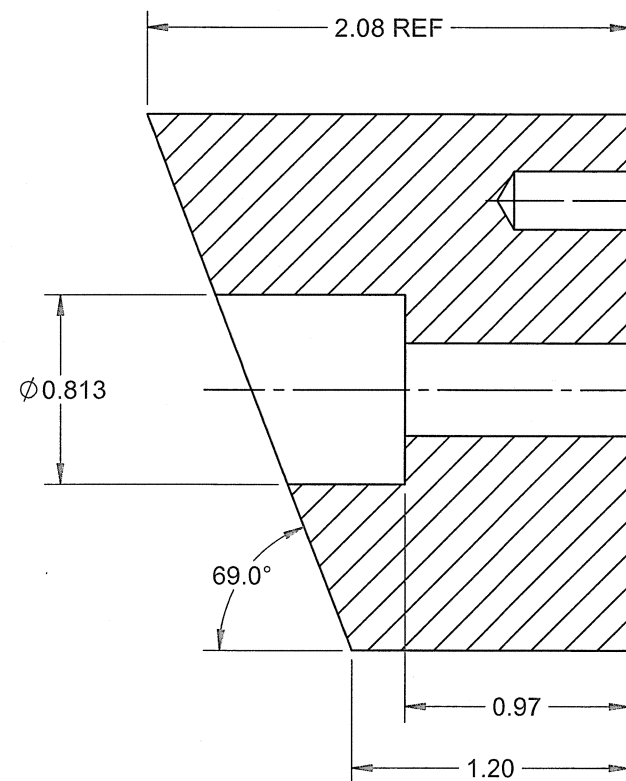


C250-C-18 BUMPER ASSEMBLY

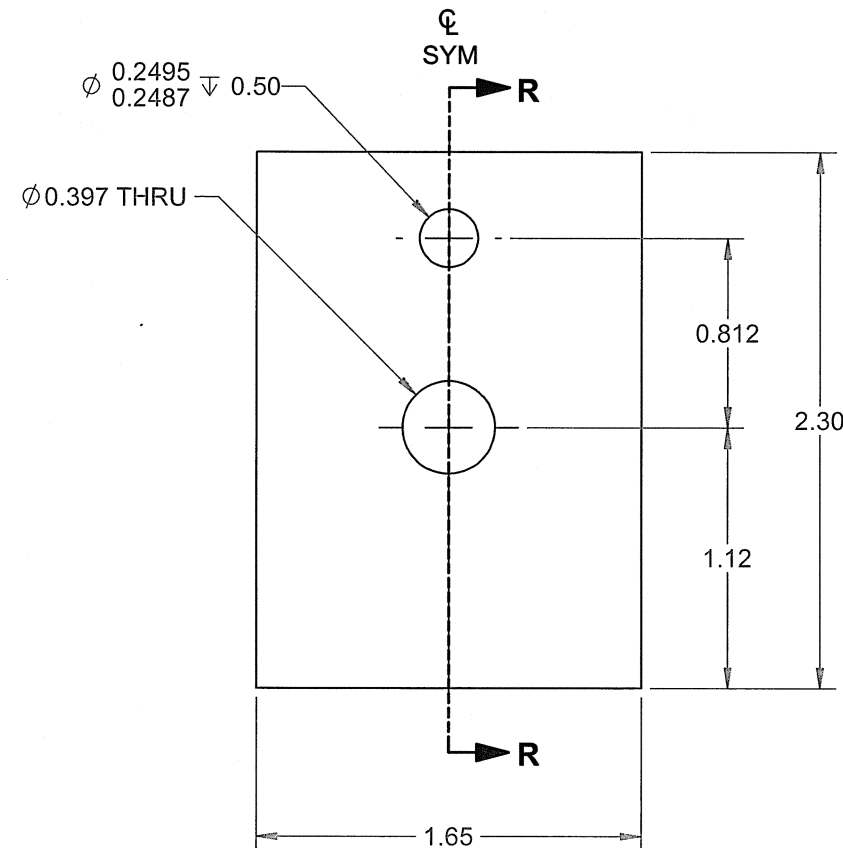
NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: N/A
7) ASSEMBLE AS SHOWN
8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM 31 WITH ITEM -19, AND REMOVE EXCESS

UNDER REVIEW
URF 19-891 19.09.09 (KT)

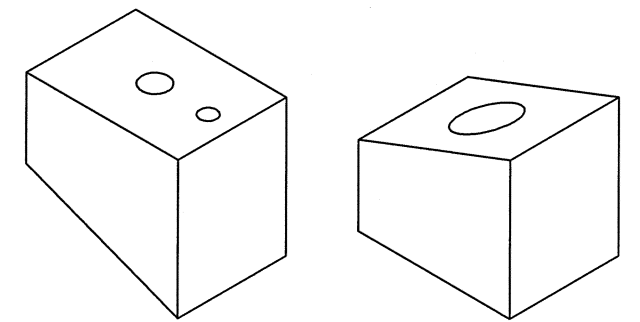
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. C
MFG. APPR.	DD	C250-C	SHEET 21 OF 22
APPROVED	WJ	TITLE	SCALE
		C250 CAGE ASSEMBLY	NTS
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SECTION R-R



C250-C-19 BUMPER



UNDER REVIEW
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- NOTES:
- 1) MATERIAL: UHMW
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
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